

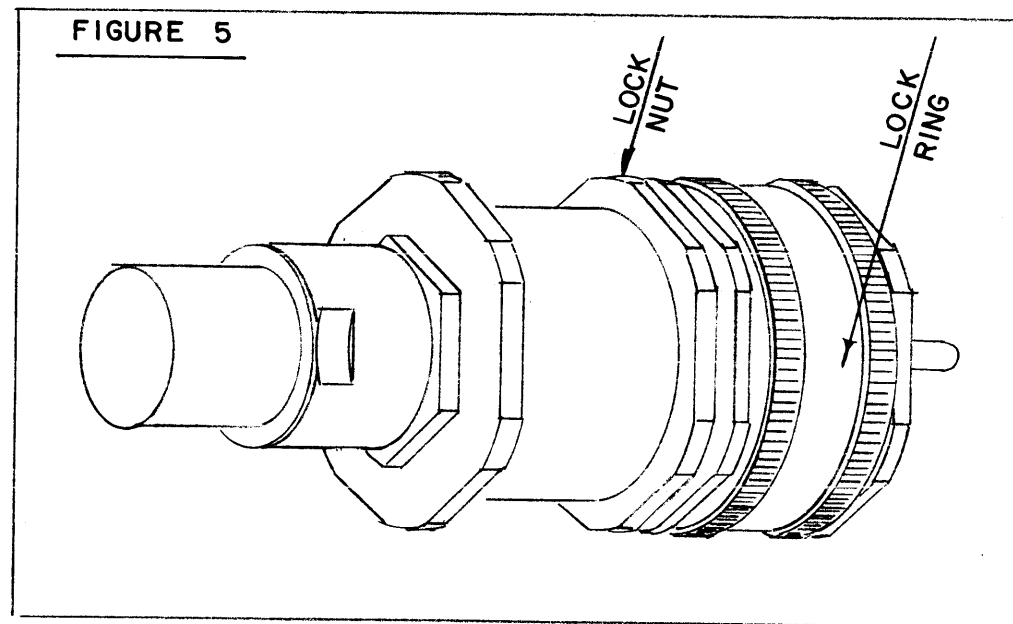
**ASSEMBLY PROCEDURE**

1. Disassemble plug and layout as shown. (Figure 1)
2. Remove approximately 3" of outer jacket, being careful not to nick braid. (Figure 2)
3. Slide cap, clamp nut, washer, clamp gasket over cable as shown. (Figure 3)
 

**Note:** V groove of gasket must face towards braid clamp.
4. Slide clamp over braid so that internal shoulder butts flush against end of outer jacket. (Figure 3)
5. With clamp in place, comb out braid and fold back smoothly over braid clamp. Trim off excess strands. (Figure 3)
6. Slide body carefully over clamp nut as far as it will go and tighten. For this operation, hold body rigid and rotate clamp nut. (Figure 4)
7. Using sharp knife, remove 5/8" of dielectric, exposing 1/2" of conductor. Be careful not to nick conductor. (Figure 4)
8. Use TMC tool (TP-106) to shape dielectric as shown by dotted lines. Tool must butt against contact fingers to obtain proper shape and length. (Figure 4)
 

**Note:** When tube (PM-386) is not required, form a full radius on end of conductor.  
When tube (PM-386) is required, it should butt flush against dielectric and soldered securely. Form a full radius on end of tube, remove all excess solder. Use chart for cable requirements, reference: PM-386.

**Caution:** All foreign particles must be removed.
9. Tighten cap securely over clamp nut. Hand tighten lock nut and locking ring on body as shown. (Figure 5)



CABLE	TUBE (PM-386)
RG-17/U RG-18/U	Not Required
RG-35/U RG-85/U RG-164/U	Required

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
A	1	COMPLETE REVISION	11/5/57	1		AAW	ATJ

TOLERANCES

SCALE:

DEC. DIM. ±  
FRAC. DIM. ±  
ANGULAR DIM. ±

MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
GENERAL ASSEMBLY INSTRUCTIONS CABLE TO QDL PLUGS			
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.

REQ. PER UNIT

MODEL

PROJECT NO.

ASS'Y. NO.

DATE

USED ON

FINISH & SPEC. NO.

ELEC. DES. APP.

MECH. DES. APP.

11/5/57

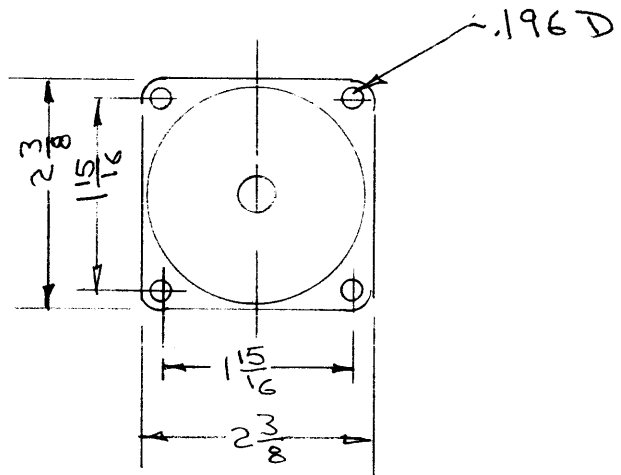
A. J. J.

FINAL APPROVAL

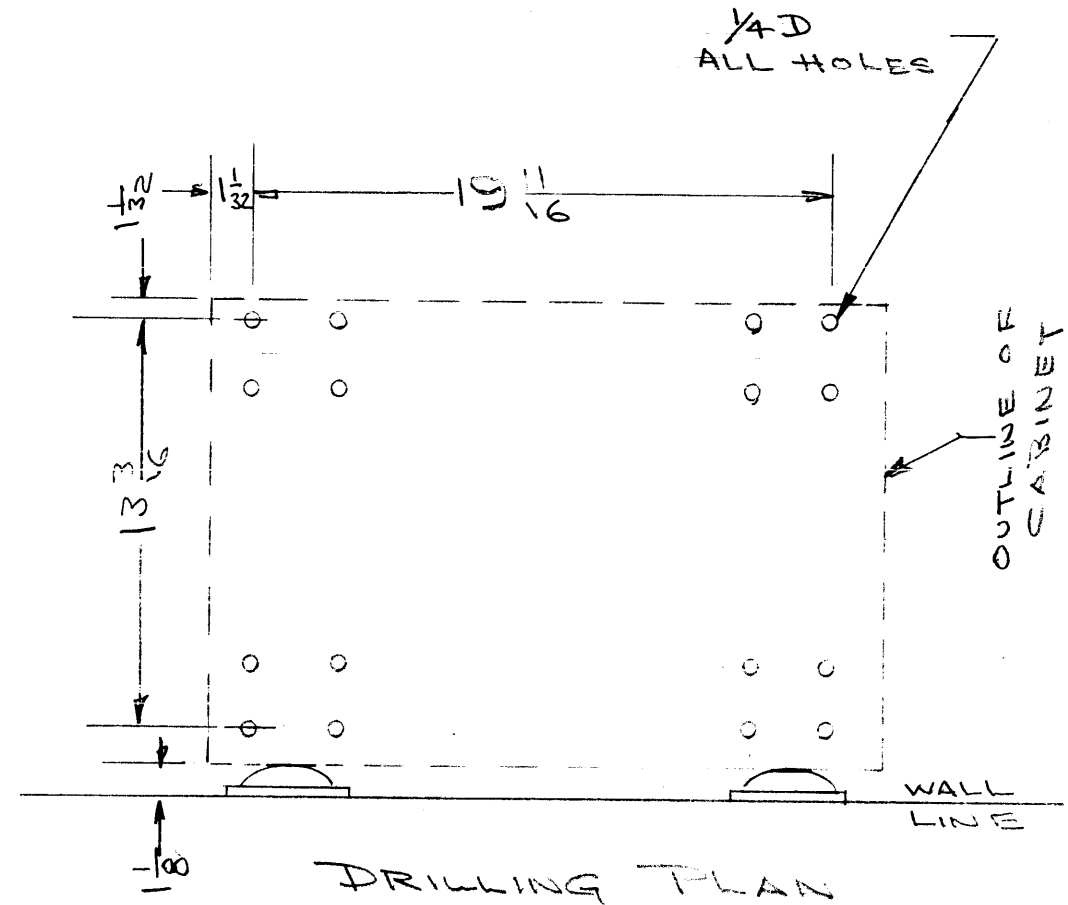
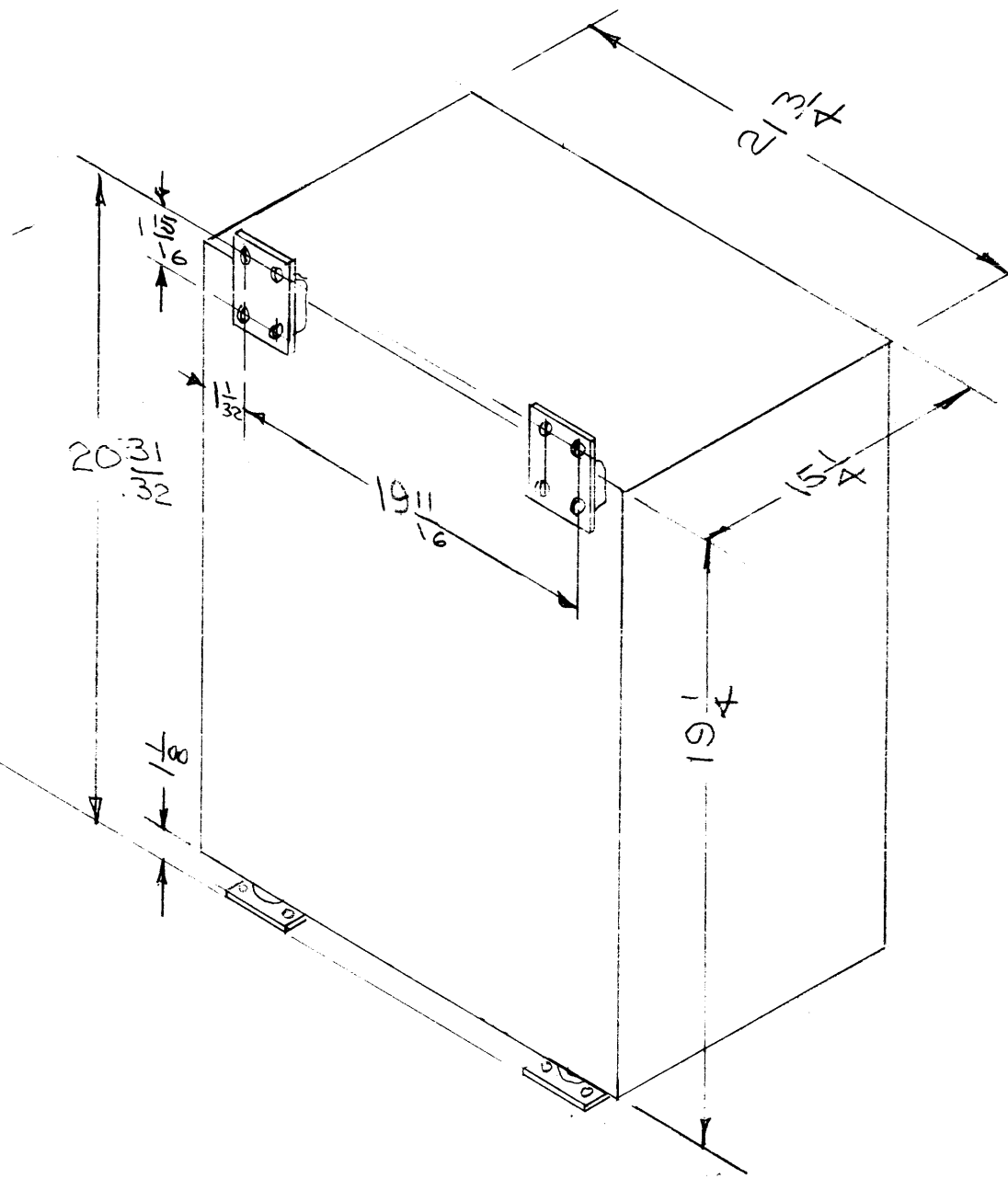
ID-202

A

ID-206 A



MOUNTING DIMENSIONS FOR SHOCK ABSORBERS



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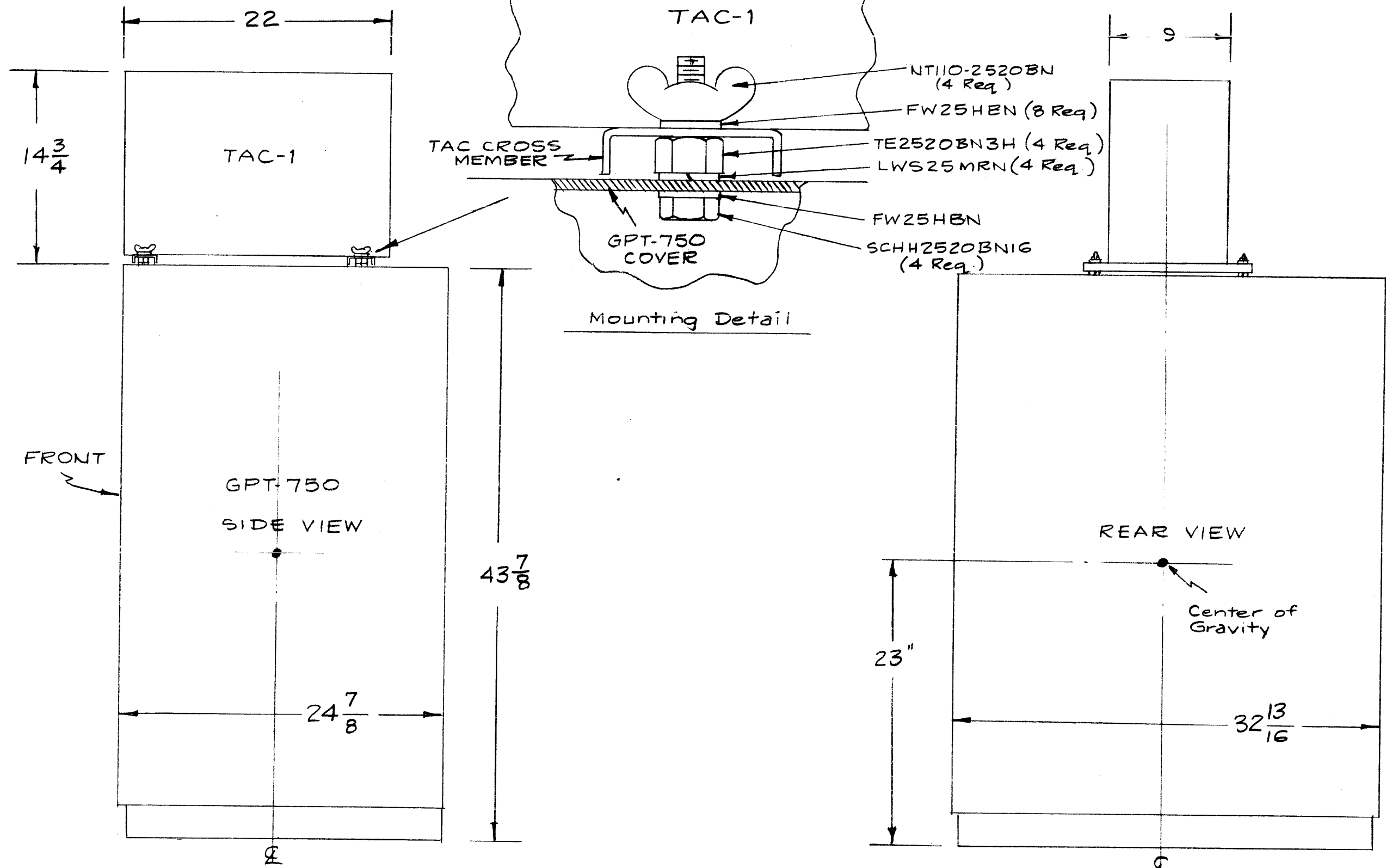
Property of:

THE TECHNICAL MATERIEL CORPORATION  
MAMARONECK, NEW YORK

A	1	19 11/16 WAS 17 3/16	830 57	1	SC	<i>[Signature]</i>	<i>[Signature]</i>	
ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.	
TOLERANCES			SCALE:					
DEC. DIM. ±			MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES					
FRAC. DIM. ±								
ANGULAR DIM. ±								

REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.	DATE
USED ON				

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
STOCK SIZE		<b>THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK</b>	
MATERIAL		CABINET, SHOCK MOUNTED	
TYPE & TEMPER		FOR GPR-90RX & MSR-1	
HEAT TREAT. SPEC.		SC	AM
FINISH & SPEC. NO.		DRAWN	CHECKED
ELEC. DES. APP.		FINAL APPROVAL	
MECH. DES. APP.		ID-206 A	



Note - When Mounting TAC-1 to GPT-750, Remove Four Existing Plug Buttons (HB-101-9)

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
A	1	HARDWARE CLARIFIED	4-24-63	8795			

TOLERANCES		SCALE:
DEC. DIM. ±	MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES	
FRAC. DIM. ±		
ANGULAR DIM. ±		

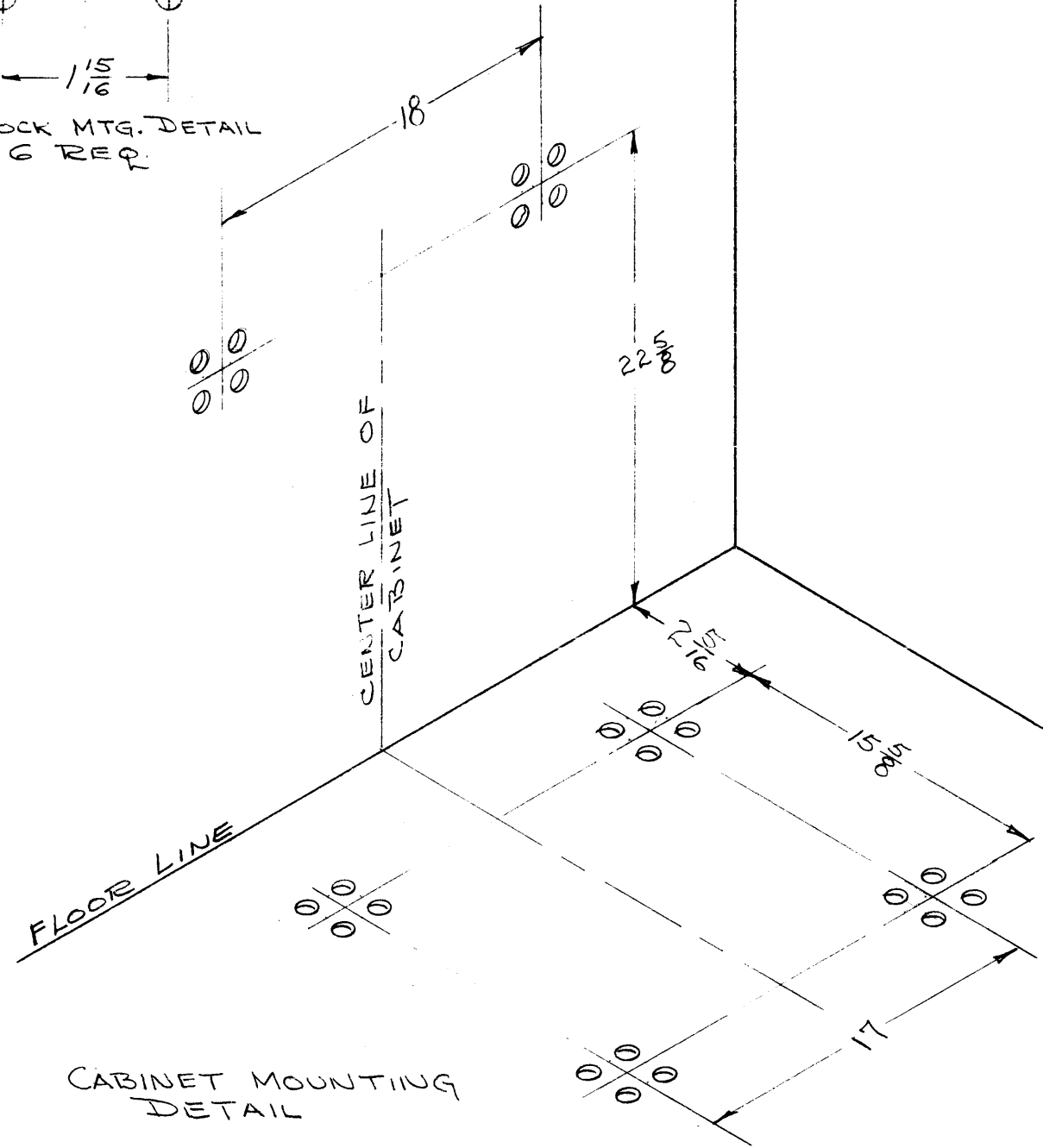
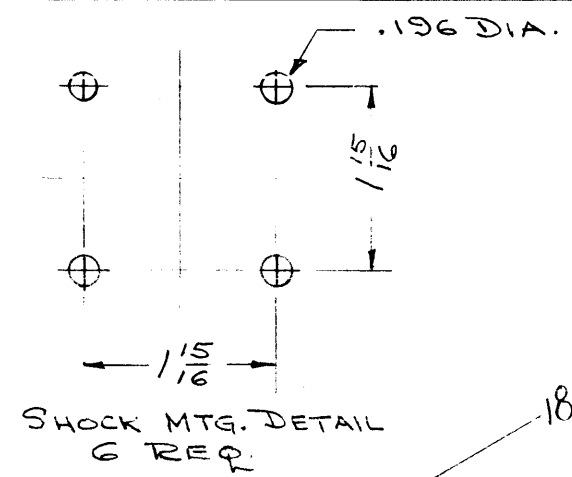
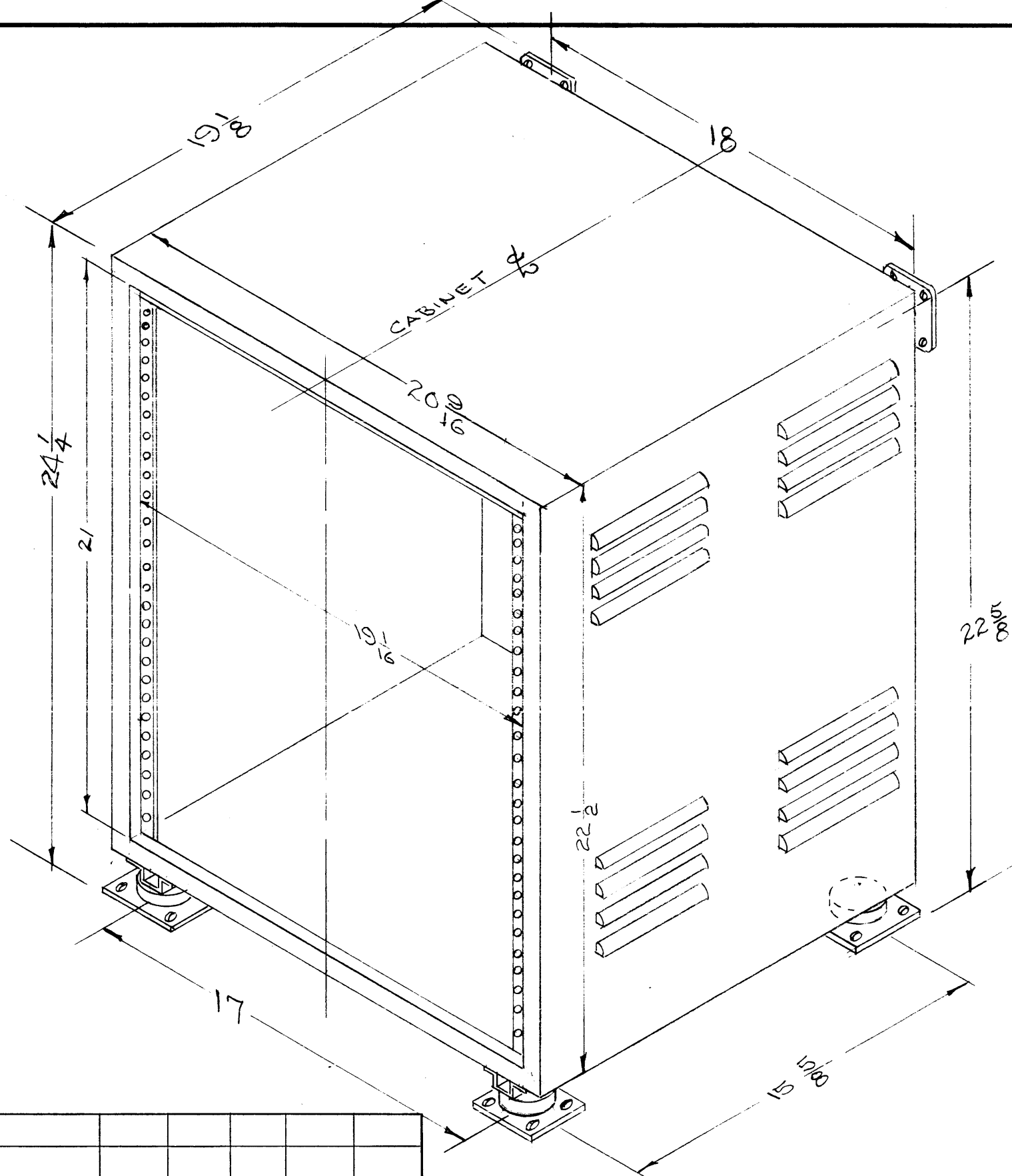
1	TAC-1			1-15-58
REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.	DATE
USED ON				

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
INSTALLATION, TAC to GPT-750			
MATERIAL		16 1/16 58	ATT
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.





ID-214



CABINET MOUNTING DETAIL

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES			SCALE: NONE				
DEC. DIM. ±			MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES				
FRAC. DIM. ± 1/64							
ANGULAR DIM. ±							

1	CY-2416/U	A-1524	9-3-58
1	RAK-4	A-1524	4-7-58
REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.
			DATE
USED ON			

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP. MAMARONECK. NEW YORK	
	STOCK SIZE	CABINET INSTALLATION	
	MATERIAL	RAK-4, (CY-2416/U)	
		SA	
	TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN
			CHECKED
	FINISH & SPEC. NO.	ELEC. DES. APP.	MECH. DES. APP.
			SA
			ID-214

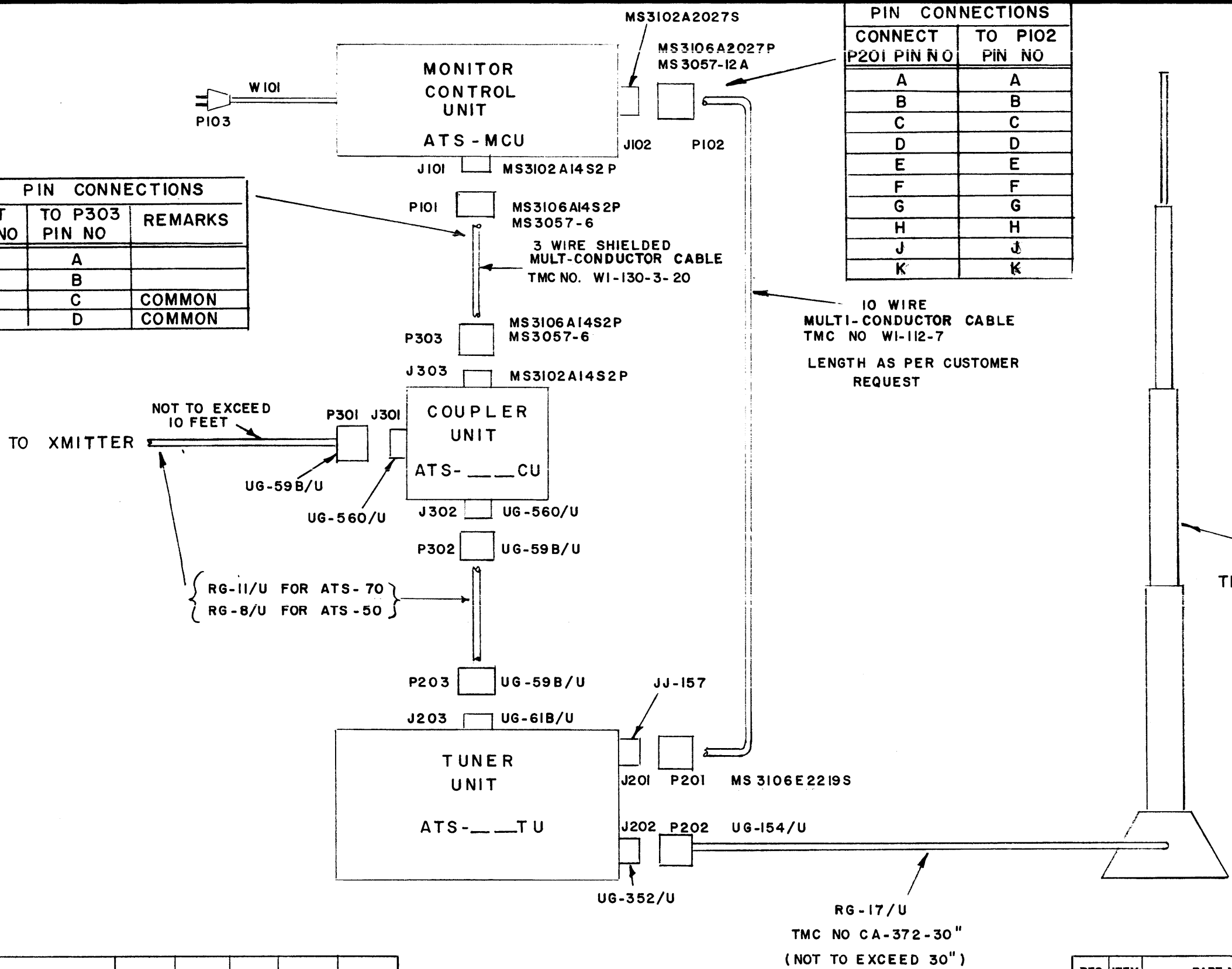
ID-215

PIN CONNECTIONS		
CONNECT PIO1 PIN NO	TO P303 PIN NO	REMARKS
A	A	
B	B	
C	C	COMMON
D	D	COMMON

PIN CONNECTIONS	
CONNECT P201 PIN NO	TO PIO2 PIN NO
A	A
B	B
C	C
D	D
E	E
F	F
G	G
H	H
J	J
K	K

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NOTE:  
 ANTENNA NOT SUPPLIED WITH ATS SYSTEM.

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES			SCALE:				
DEC. DIM. ±			MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES				
FRAC. DIM. ±							
ANGULAR DIM. ±							

REQ. PER UNIT	ATS	PROJECT NO.	ASS'Y. NO.	DATE
	MODEL			4-9-58
USED ON				

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
INTERCONNECT DIAGRAM			
ATS SYSTEM			
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.

ID-215

10-216

**PHYSICAL CHARACTERISTICS OF ANTENNA**

- MATERIAL: - Stainless Steel
- CONSTRUCTION: - 6 Telescopic Sections
- EXTENDED LENGTH: - 35' 7"
- COLLAPSED LENGTH: - 6' 1/4"
- BASE (6th) SECTION: - OD 1.5", ID 1.37"
- WEIGHT: - 19 lbs.

**PHYSICAL CHARACTERISTICS OF HEAVY-DUTY BASE INSULATOR**

- BASE MATERIAL: - Chrome plated brass
- INSULATOR MATERIAL: - Brown glazed porcelain
- COMPRESSION RATING: - 10,000 lbs.
- HEIGHT: - 8"
- MOUNTING DIMENSIONS: - see illustration
- WEIGHT: - 8 lbs.

ANTENNA TMC #AW-101-4

TOP ANTENNA SECTION

SECOND ANTENNA SECTION

THIRD ANTENNA SECTION

FOURTH ANTENNA SECTION

FIFTH ANTENNA SECTION

ANTENNA BASE SECTION

The antenna will withstand wind velocities of 60 mph when mounted with supplied base. When guy wires are installed as shown the antenna will withstand velocities in excess of 100 mph.

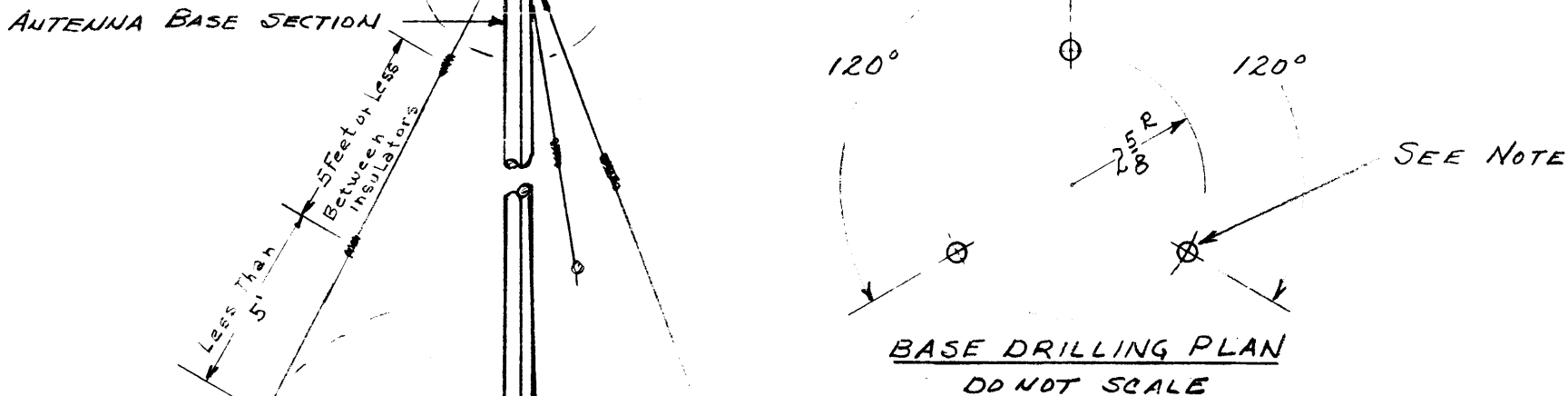
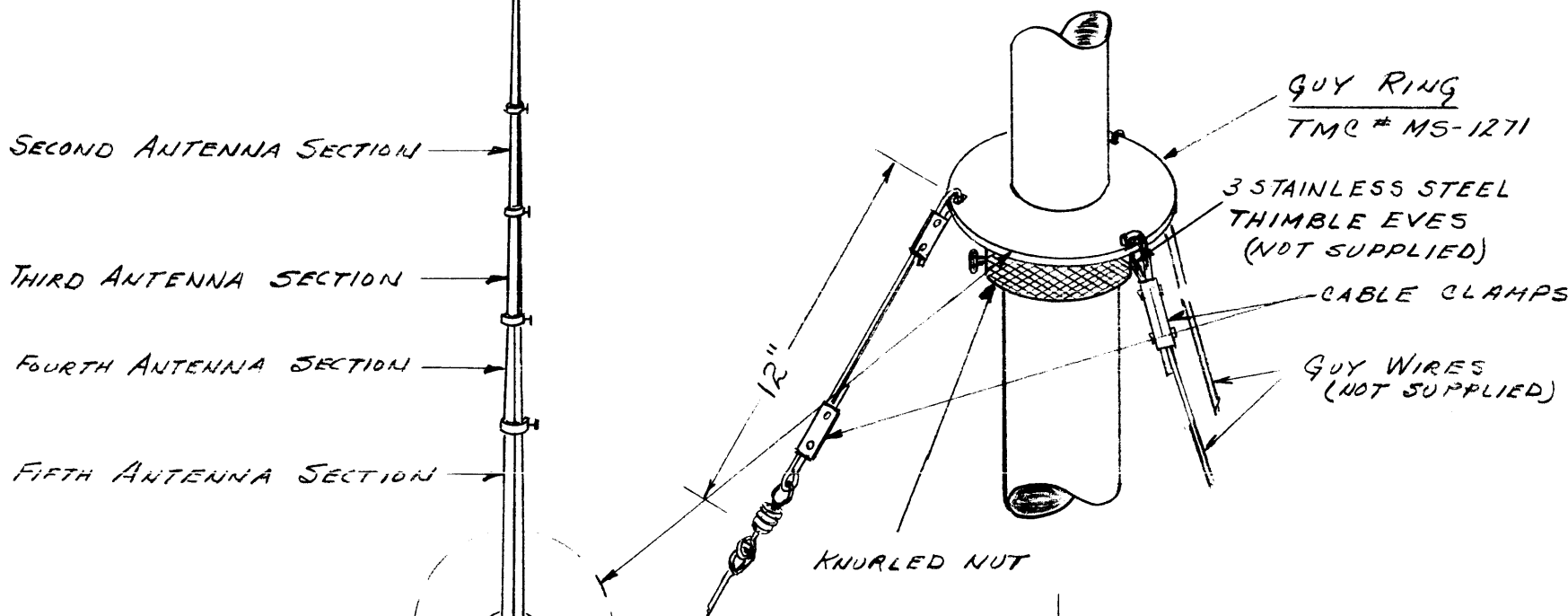
Three guy wires are to be attached firmly to the guy ring (supplied) at the mast and to stationary supports placed 120° apart at a minimum radius of 6 feet from the base of the antenna.

Guy wires so installed will each exceed 8' in length. Each guy must be divided by an insulator so that the electrical length of the segments formed will be 5 ft. or less in length.

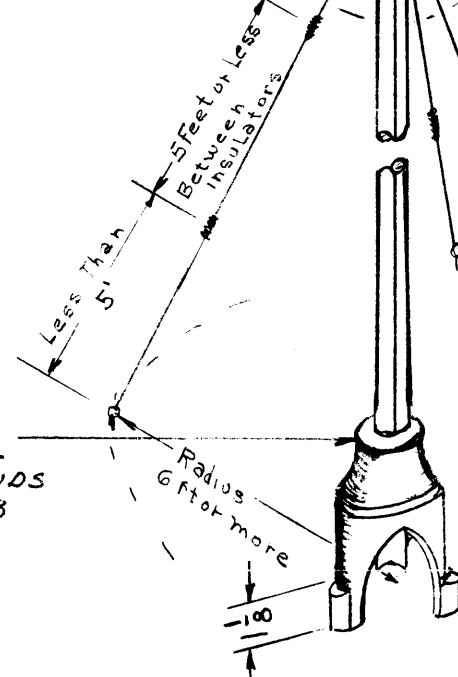
It is recommended that 1/8" diameter stranded 1x7 or 7x7 rope of either stainless steel, phosphor bronze, or vinyl jacketed steel be used for guys. Suitable non-corrosive cable clamps should be used to fasten guys. These items are not supplied.

Three stainless steel bolts are provided for mounting the antenna Base Insulator. They are 2 3/4" long and will fit a 3/8-16 nut or tapped hole.

The use of thimbles is recommended at the guy ring.



BASE INSULATOR WITH MOUNTING STUDS TMC # AB-101-9B



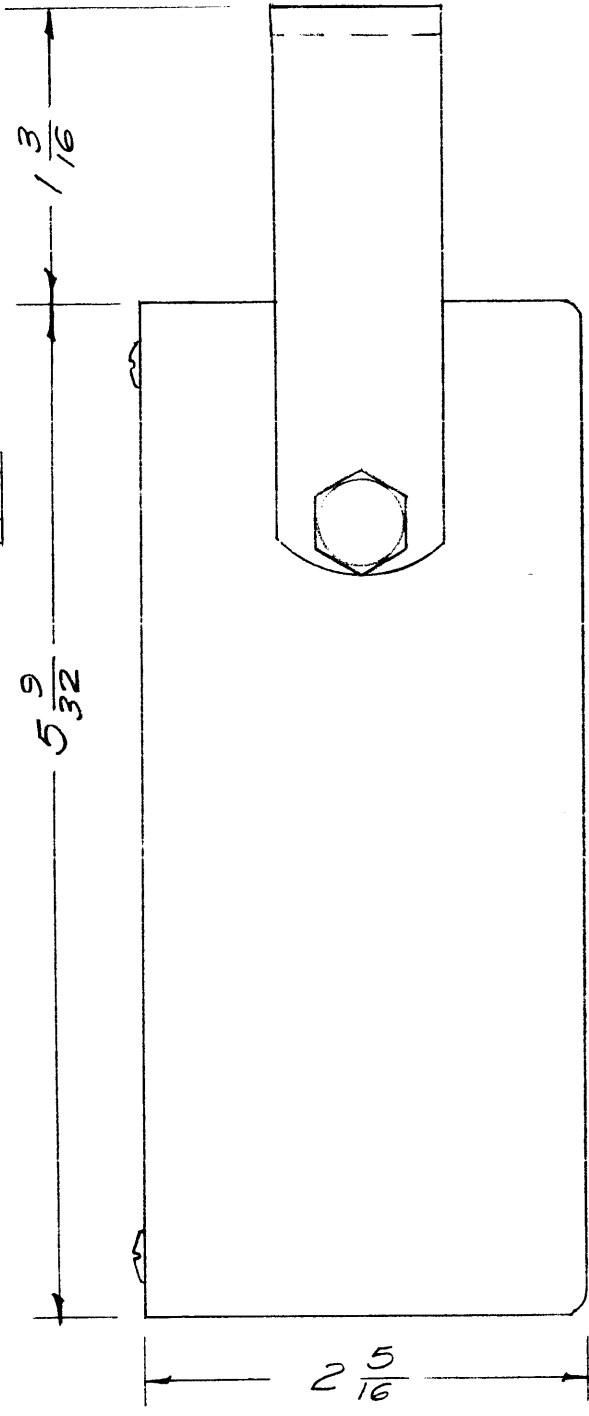
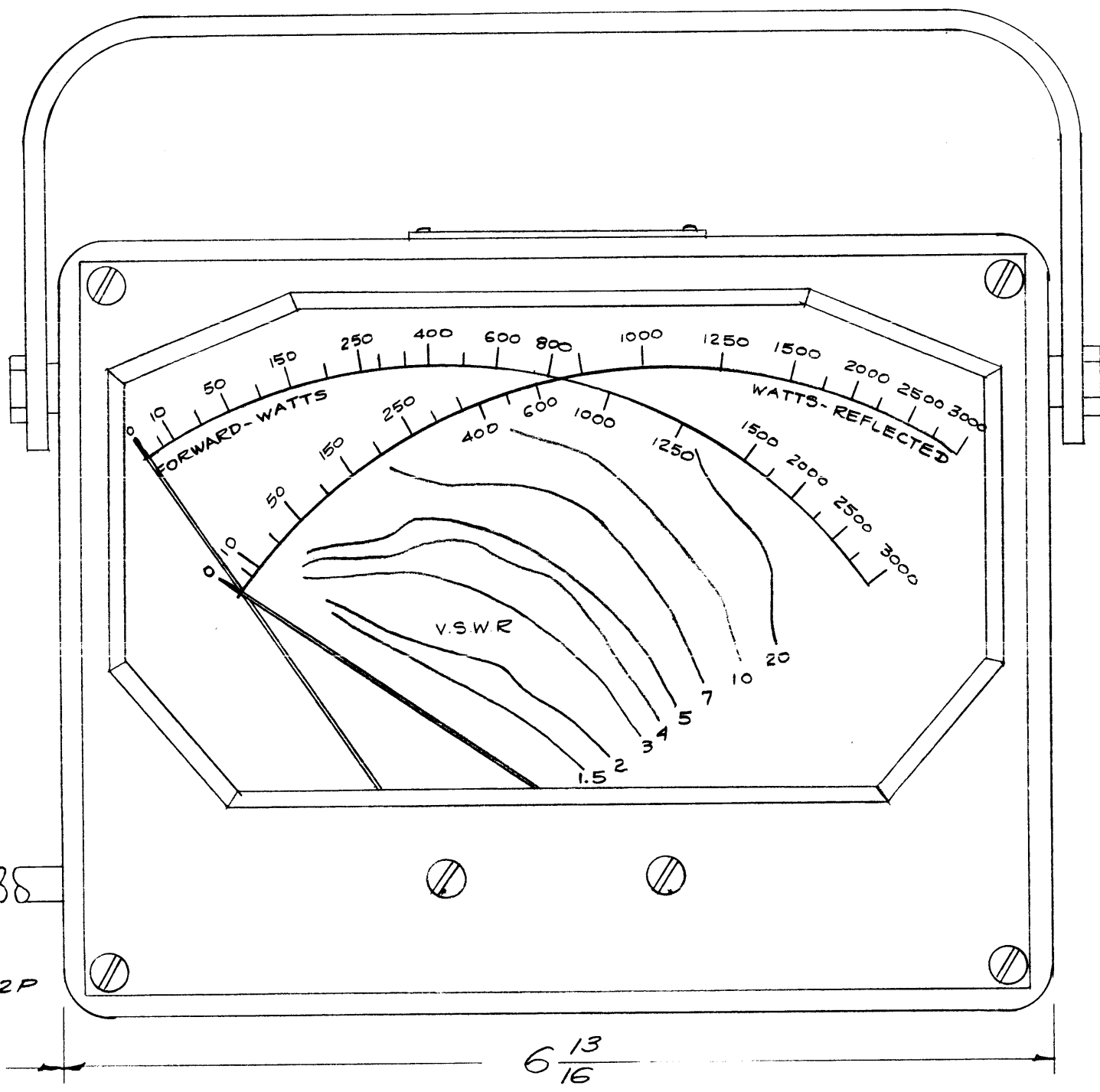
A	1	COMPLETELY REVISED	6/12/58	1	AWC		JSR
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TOLERANCES			SCALE:				
DEC. DIM. ±			MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES				
FRAC. DIM. ±							
ANGULAR DIM. ±							

REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.	DATE
USED ON				

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
STOCK SIZE			
VERTICAL WHIP ANTENNA INSTALLATION			
MATERIAL			
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED
		5/20/58 AWC	JSR
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.
			10-216 A



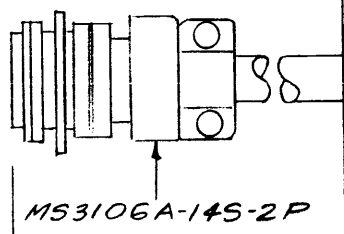
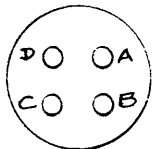
ID-221



**MECHANICAL DATA-**  
 Case Black Bakelite  
 Front Plate Aluminum, Black  
 Gloss Enamel Finish  
 Handle Rubber Covered Metal

**Scale Colors**  
 Forward Watts Black  
 Reflected Watts Red  
 V.S.W.R. Blue

**ELECTRICAL DATA**  
 Resistance -  
 Connector Pins A & C - 1700 Ω ± 20%  
 Connector Pins D & C - 1700 Ω ± 20%  
 Range 0-90 μamps ± 2%



ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES							SCALE: BA-1553
DEC. DIM. ±		MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES					
FRAC. DIM. ±							
ANGULAR DIM. ±							

1	SWR-3000 PM				
REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.	DATE	
USED ON					

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
<b>THE TECHNICAL MATERIEL CORP.</b>			
MAMARONECK, NEW YORK			
DIMENSIONAL OUTLINE, MODEL SWR-3000 PM			
MATERIAL		16 6/23/58	JSR
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED
FINISH & SPEC. NO.		ID-221	
		ELEC. DES. APP.	MECH. DES. APP.









ID-229

REPLACEMENT OF VACUUM CAPACITOR G113 (AM-108)

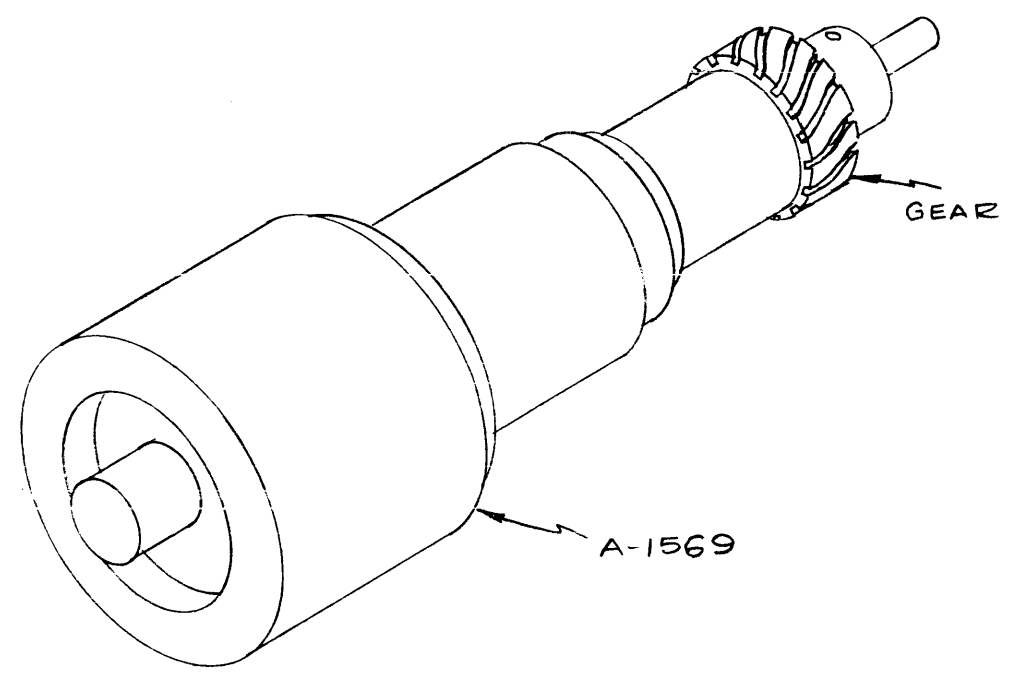
Set Counter on Panel to read 99 6.

Remove Plate Connection on top of Capacitor

Loosen Screw on Clamping Bracket on side of Capacitor; which is located on top of Chassis.

Loosen Vertical gear set screws.

Carefully remove Capacitor by lifting straight up Gear and Capacitor will come out as one unit.



SEE PRELIMINARY CHECK BEFORE MOUNTING

Insert new Capacitor Assembly and fully engage gears.

Tighten set screws in vertical gear; Screws on Bracket and reconnect Plate Capacitor.

Check reading on Front Panel. Stops should remain between 99 6 and 22 3

PRELIMINARY CHECK

Rotate shaft and gear clockwise; until the rotor of the Capacitor begins to move; then add 1/4 more turn.

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TOLERANCES			SCALE: $\frac{1}{16}$				
DEC. DIM. $\pm$			MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES				
FRAC. DIM. $\pm$							
ANGULAR DIM. $\pm$							

1	RTF	GPT-750	9-5-58
REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.
USED ON			

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
<b>THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK</b>			
STOCK SIZE			
REPLACEMENT OF VACUUM CAPACITOR			
MATERIAL			
		(AM-108)	
		16 9/16 58	
		<i>[Signature]</i>	<i>[Signature]</i>
		DRAWN	CHECKED
		FINAL APPROVAL	
			ID-229
		ELEC. DES. APP.	MECH. DES. APP.

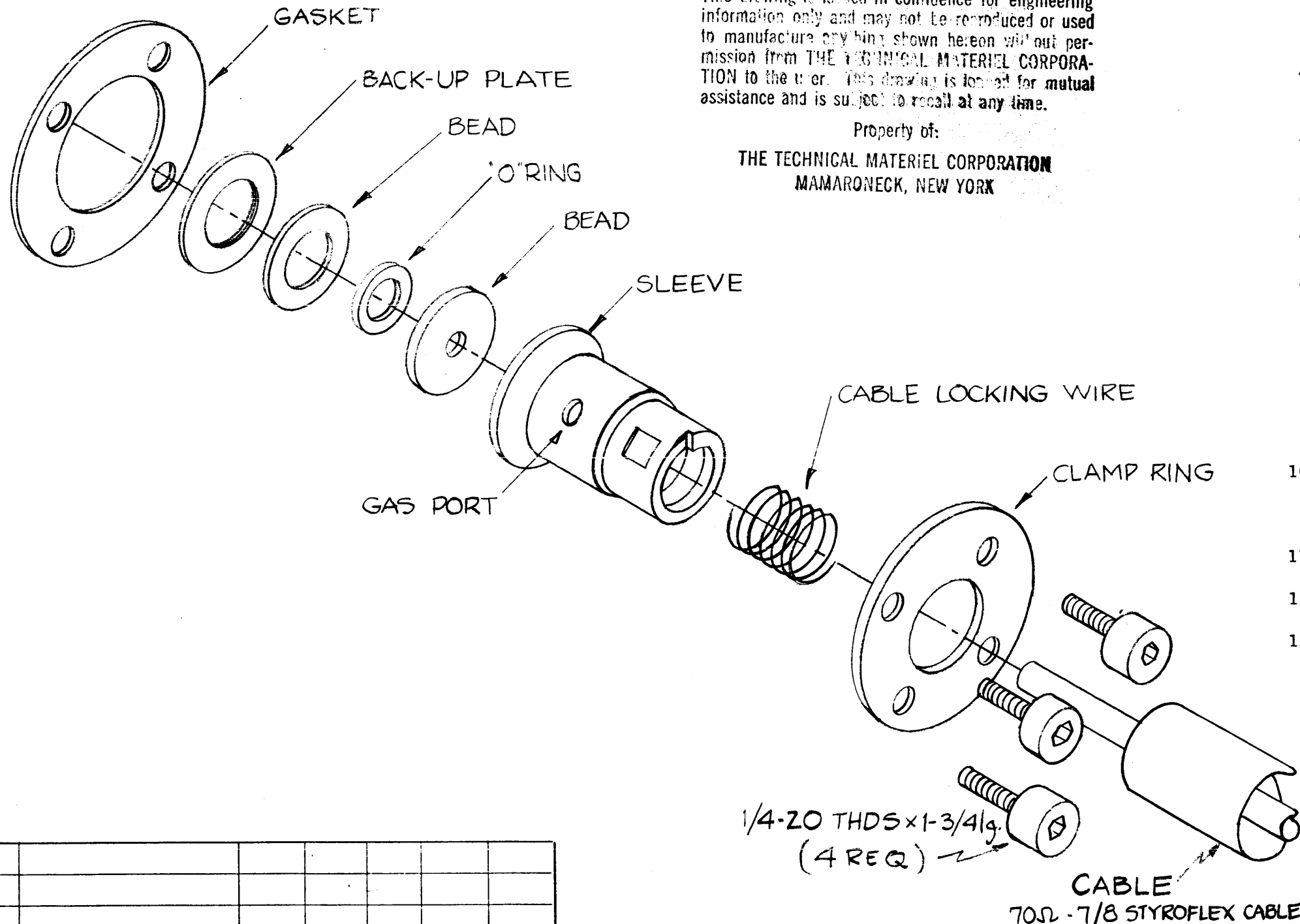


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1. Using a sharp tubing cutter, score cable 1" to 2" from end. Do not cut through aluminum jacket.
2. Using emery cloth, clean a section of the aluminum jacket approximately 1" long centered on scored groove. The emery cloth should be used in shoeshine fashion and all scratches and marks must be removed from jacket. The "O" ring used to seal connector seats against this surface and therefore any scratches or defects may cause leaks in the finished assembly. Brush off sanding dust from jacket.
3. Grip end of cable in vise and flex cable gently until the aluminum jacket fractures at the scored groove. Do not break the Styrene sleeve just under the aluminum jacket. Pull back on the cable until 1/8" of Styrene sleeve is exposed.
4. Using hot knife tool, cut Styrene sleeve and Helix down to center conductor flush with aluminum jacket. Pull off short end of jacket and Styrene.
5. Cut off center conductor 2-1/2 inches from end of cable. Remove cut-off burr from center conductor. Take care not to allow chips to enter cable.
6. Slide clamp ring over cable. Check roundness and size of cable using sleeve as gage. The sleeve should slide freely over cable.
7. Grease sleeve "O" ring with "O" ring grease, Dow Corning No. 4 compound, and install in sleeve.
8. Push on wire coil over jacket until coil is entirely on jacket and rear end of coil is approximately 3/8" from end of jacket. Coat inside of sleeve with anti-seize compound. Use the compound sparingly and wipe off any excess before starting sleeve on cable.
9. Push sleeve over cable until wire end enters notch and is in line with thread groove. Turn sleeve clockwise, making certain that wire is engaged in thread and is not turning with sleeve. Turn on sleeve until cable butts internal shoulder.
10. Push bead over center conductor with countersink facing outward. Apply "O" ring grease, Dow Corning No. 4 compound, to small "O" ring and push it on center conductor. Push second bead on center conductor with countersink facing inward.
11. Place back-up plate over center conductor and push toward sleeve so that beads and back-up plate seat in sleeve counterbores.
12. Bring up sleeve assembly to box and place gasket over tapped holes in box.
13. Bring clamp ring up to box and clamp entire assembly with four (4) bolts and lockwashers.

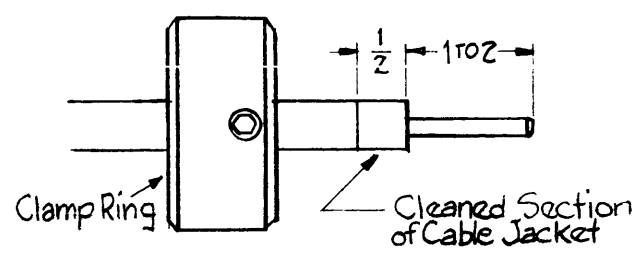
\* SUPPLIED BY TMC  
GL-118 (DOW CORNING #4 COMPOUND)  
GL-117 (LUBRICANT, THREAD)

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES			SCALE:				
DEC. DIM. ±			MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.				
FRAC. DIM. ±			REMOVE ALL BURRS AND SHARP EDGES				
ANGULAR DIM. ±							

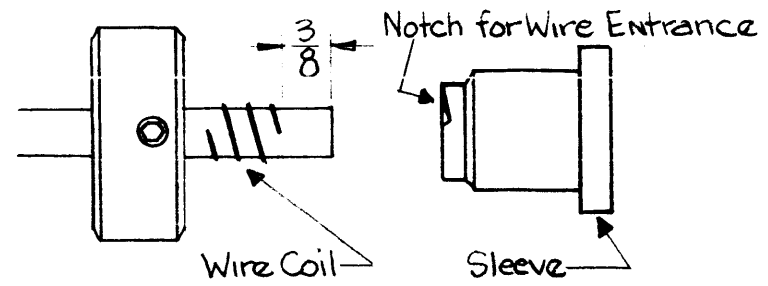
REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.	DATE
	ESW-787			5-24-60
USED ON				

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
INSTALLATION ASSEMBLY MODEL ESW 787			
TYPE & TEMPER		HEAT TREAT. SPEC.	DATE
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.

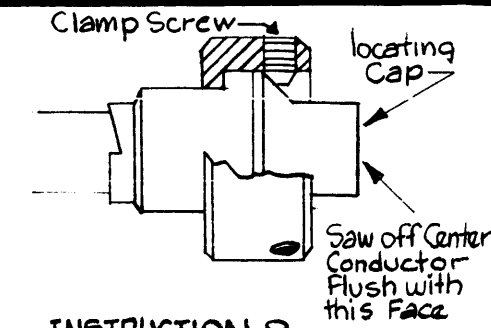
ID-237



INSTRUCTIONS 1 THRU 5



INSTRUCTIONS 6 THRU 8



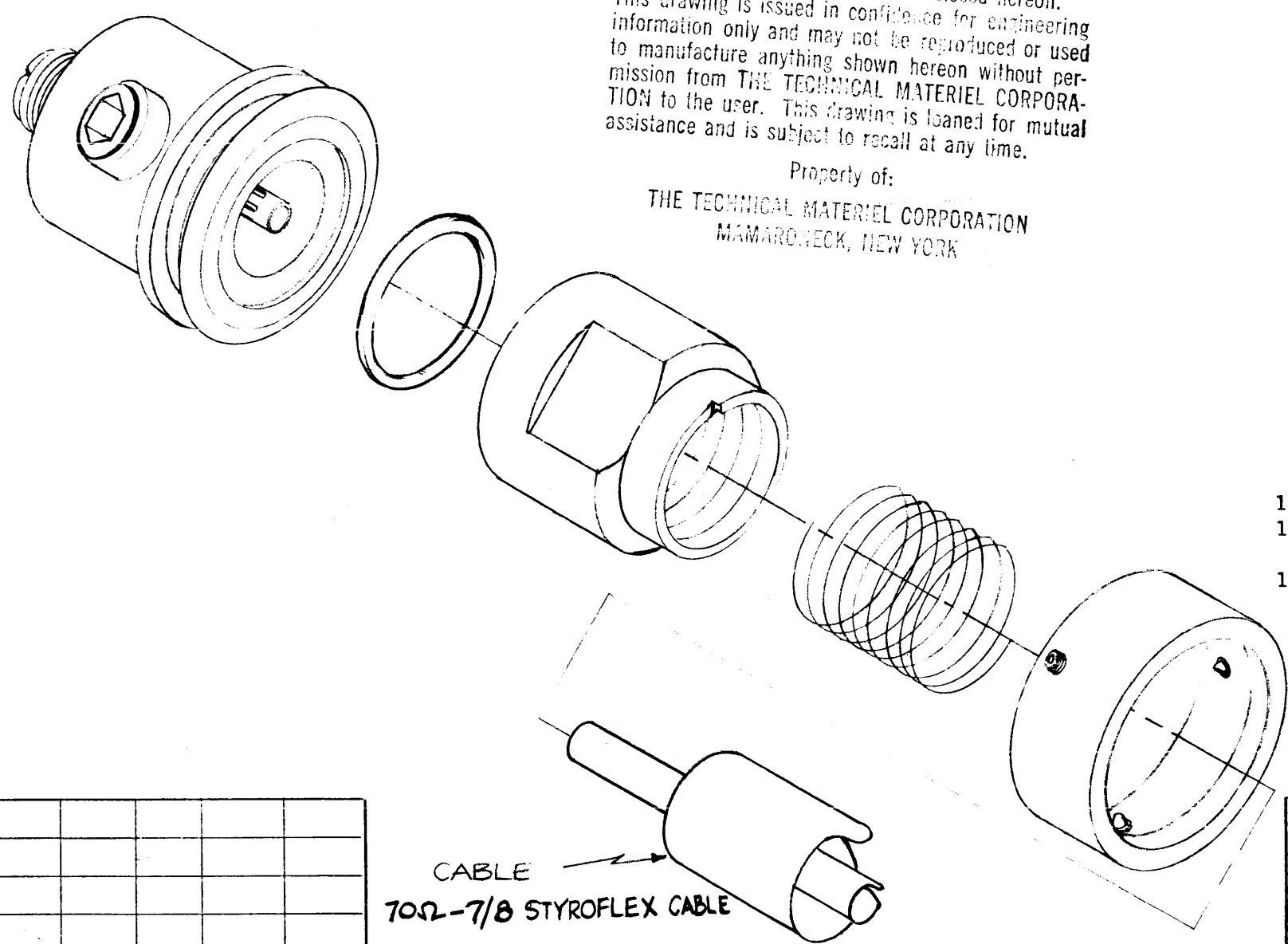
INSTRUCTION 9

1. Using a sharp tubing cutter, score cable 1" to 2" from end. Do not cut through aluminum jacket.
2. Using emery cloth, clean a section of the aluminum jacket approximately 1" long centered on scored groove. The emery cloth should be used in shoeshine fashion and all scratches and marks must be removed from jacket. The O ring used to seal connector seats against this surface and therefore any scratches or defects may cause leaks in the finished assembly. Brush off sanding dust from jacket.
3. Grip end of cable in vise and flex cable gently until the aluminum jacket fractures at the scored groove. Do not break the Styrene sleeve just under the aluminum jacket. Pull back on the cable until about 1/8" of Styrene sleeve is exposed.
4. Using hot knife tool, cut Styrene sleeve and helix down to center conductor flush with aluminum jacket. Pull off short end of jacket and Styrene. Remove burr from center conductor.
5. Slide clamp ring over cable with counterbore facing end of cable.
6. Check roundness and size of cable using sleeve as gage. The sleeve should slide freely over cable.
7. Push on wire coil over jacket until coil is entirely on jacket and rear end of coil is approximately 3/8" from end of jacket. Coat inside of sleeve with anti-seize compound. Use the compound sparingly and wipe off any excess before starting sleeve on cable.
8. Push sleeve over cable until wire end enters notch and is in line with thread groove. Turn sleeve clockwise, making certain that wire is engaged in thread and is not turning with sleeve. Turn on sleeve until it is completely on cable and cable end projects approximately 1/16" from flange end of sleeve.
9. Bring up locating cap over center conductor and clamp to sleeve with clamp ring. This is used as an installation jig to assure correct placement of sleeve on cable and to cut center conductor to proper length. Put wrench on sleeve and turn entire assembly approximately 1 turn until end of cable jacket bottoms in locating cap counterbore. Saw off center conductor flush with end of locating cap.
10. Remove locating cap and remove burr from center conductor.
11. Grease O ring with O ring grease (Dow Corning 4 Compound) and mount over cable end in sleeve counterbore.
12. Bring up connector body, making certain that center conductor enters center contact. Complete assembly by tightening the three clamp screws.

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MAMARONECK, NEW YORK



CABLE  
702-7/8 STYROFLEX CABLE

\* SUPPLIED BY TMC  
GL-118 - (DOW CORNING #4 COMPOUND)  
GL-117 - (LUBRICANT, THREAD)

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES			SCALE:				
DEC. DIM. ±			MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.				
FRAC. DIM. ±			REMOVE ALL BURRS AND SHARP EDGES				
ANGULAR DIM. ±							

REQ. PER UNIT	MODEL	PROJECT NO.	ASSY. NO.	DATE
	BSA-ESW 787/UHF			5-24-60
USED ON				

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
STOCK SIZE			
MATERIAL			
INSTALLATION ASSEMBLY MODEL BSA-ESW 787/UHF			
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.

ID-237

**INSTALLATION INSTRUCTIONS**

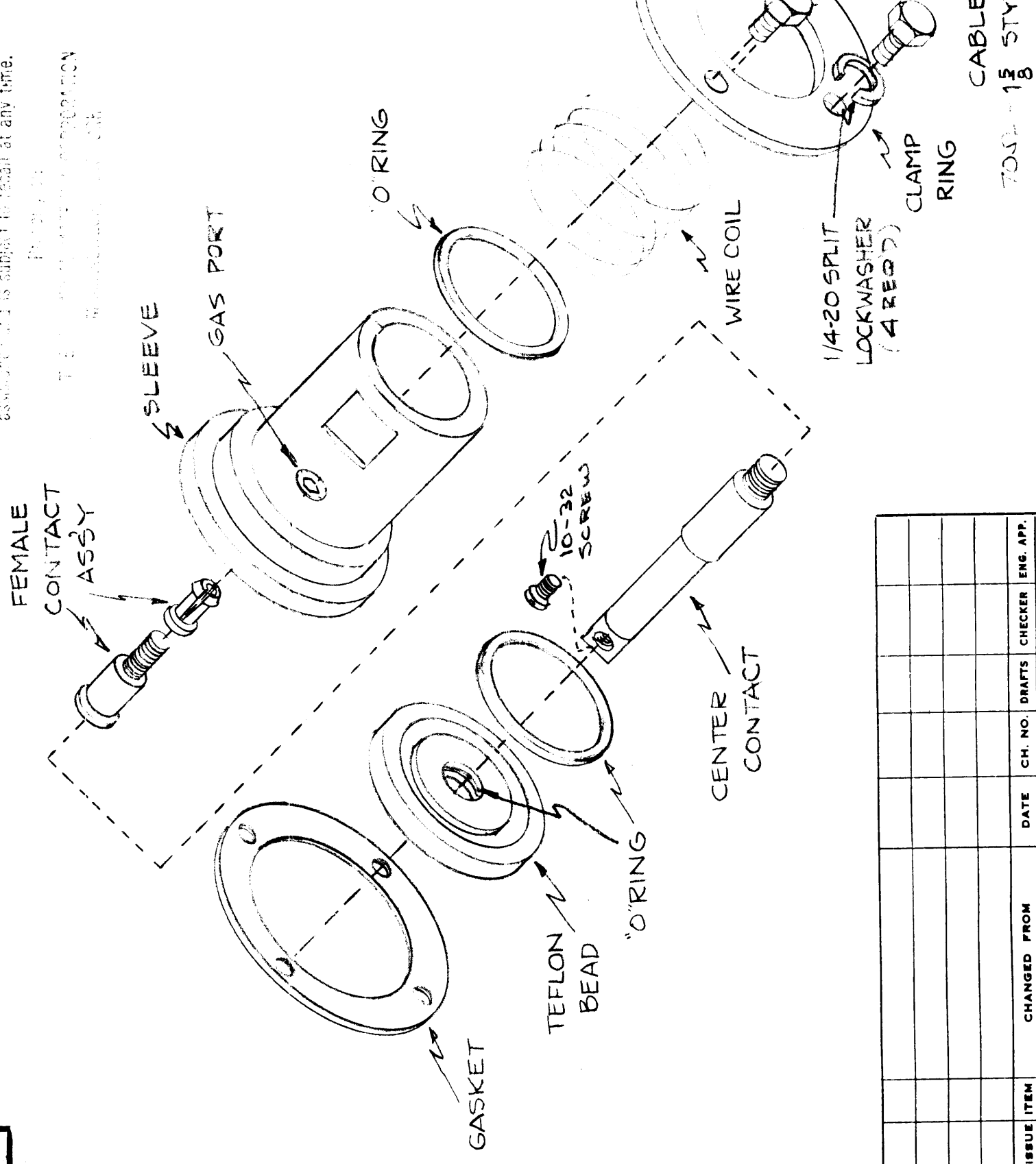
Refer to Accompanying Assembly Drawing.

- Using a sharp tubing cutter, score cable 3" from end. Do not cut through aluminum jacket.
- Using emery cloth, clean a section of the aluminum jacket approximately 1" long centered on scored groove. The emery cloth should be used in shoeshine fashion and all scratches and marks must be removed from jacket. The "O" ring used to seal connector seats against this surface and therefore any scratches or defects may cause leaks in the finished assembly. Brush off sanding dust from jacket.
- Grip end of cable in vise and flex cable gently until the aluminum jacket fractures at the scored groove. Do not break the Styrene sleeve just under the aluminum jacket. Pull back on the cable until about 1/8" of Styrene sleeve is exposed.
- Using hot knife tool, cut Styrene sleeve and Helix down to center conductor flush with aluminum jacket. Pull off short end of jacket and Styrene.
- Saw off center conductor .125 from end of cable. Make saw cut carefully so that end of center conductor is straight and square with cable axis. Remove inside and outside burrs from center conductor being careful to keep chips out of cable.
- Insert female contact assembly (female contact, anchor screw, and anchor) into center conductor of cable. If anchor is difficult to enter in center conductor, unscrew anchor several turns on screw. Insert screwdriver into head of anchor screw and push straight into center conductor until anchor screw and female contact shoulder. Tighten anchor screw until female contact is firmly seated in center conductor.
- Slide clamp ring over cable. Check roundness and size of cable using sleeve as gage. Sleeve should slide freely over cable.
- Grease sleeve "O" ring with "O" ring grease, Dow Corning No.4 Compound, and install in sleeve.
- Push on wire coil over jacket until coil is entirely on jacket and rear end of coil is approximately 3/8" from end of jacket. Coat inside of sleeve with anti-seize compound. Use the compound sparingly and wipe off any excess before starting sleeve on cable.
- Push sleeve over cable until wire end enters notch and is in line with thread groove. Turn sleeve clockwise, making certain that wire is engaged in thread and is not turning with sleeve. Turn on sleeve until cable butts internal shoulder.
- Screw center contact into female contact.
- Push bead over center contact with countersink facing outward. Grease with Dow Corning No.4 Compound and mount "O" rings in place, and mount second bead over center contact. Push entire bead assembly down into sleeve counterbore.
- Bring up sleeve assembly to box and place gasket over tapped holes in box.
- Bring clamp ring up to box and clamp entire assembly with four (4) bolts and lockwashers.

\* SUPPLIED BY TMC

GL-118 (DOW CORNING #4 COMPOUND)

GL-117 (LUBRICANT, THREAD)



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REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
	STOCK SIZE	INSTALLATION ASSEMBLY	
	MATERIAL	ESW-71625	
	TYPE & TEMPER	DRAWN	FINAL APPROVAL
	HEAT TREAT. SPEC.	CHECKED	
	FINISH & SPEC. NO.	ELEC. DES. APP. MECH. DES. APP.	ID-239

REQ. PER UNIT	MODEL	PROJECT NO.	ASSY. NO.	DATE
	ESW-71625			6-29-60

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.

SCALE: 1

MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES



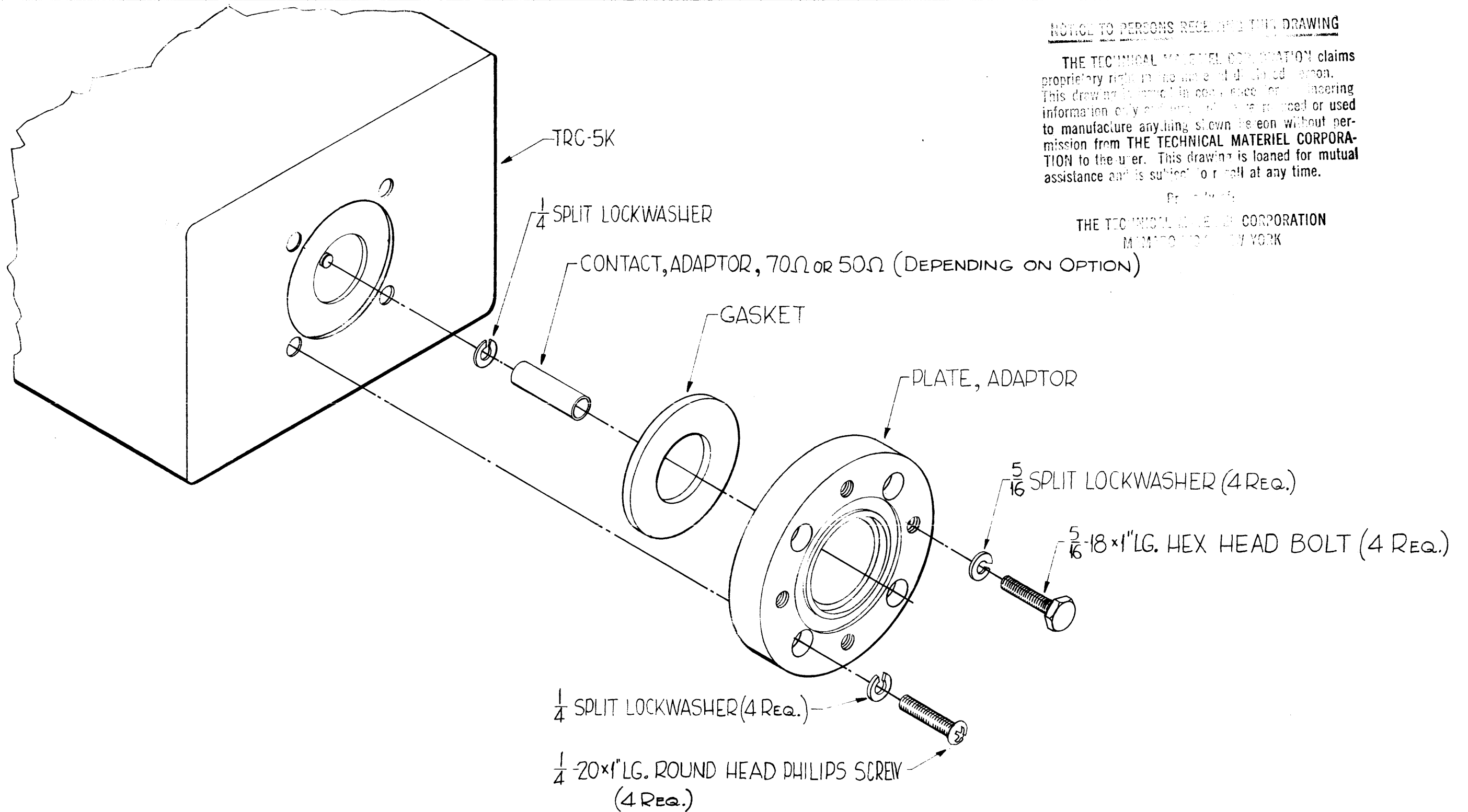


ID-263

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THE TECHNICAL MATERIEL CORPORATION  
MAMARONECK, NEW YORK



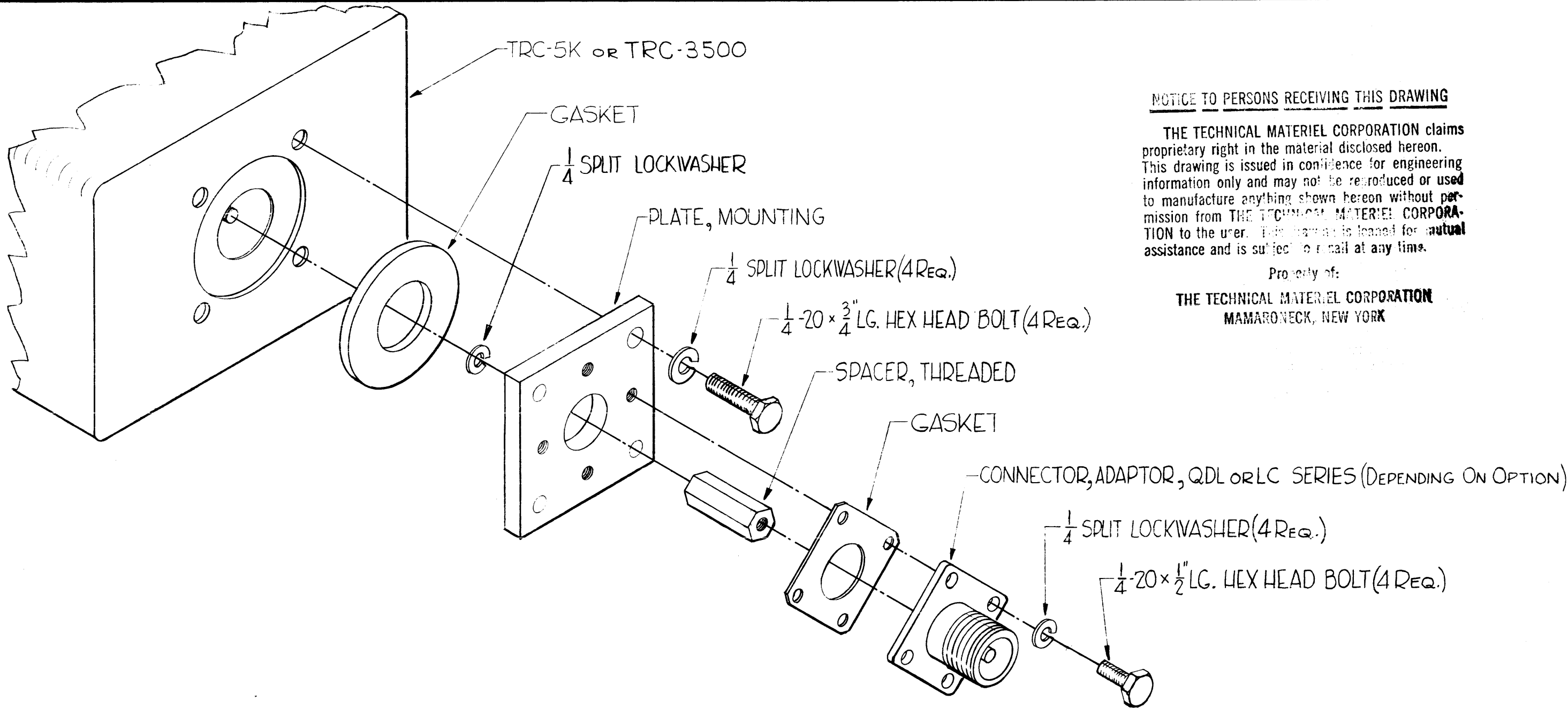
SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ON FRACTIONS ± 1/64 DECIMALS ± .005 ANGLES ± 1/2°		SCALE: MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES				

REQ. PER UNIT	MODEL	SECTION	ASS'Y. NO.	DATE
	TRC-5K			10-26-61
USED ON				

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
STOCK SIZE		INSTALLATION FOR AX-271EAX-2721 TO TRC-5K	
MATERIAL			
TYPE & TEMPER		HEAT TREAT. SPEC.	
DRAWN		CHECKER	FINAL APPROVAL
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.



ID-264



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Property of:  
**THE TECHNICAL MATERIEL CORPORATION**  
 MAMARONECK, NEW YORK

SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
UNLESS OTHERWISE SPECIFIED:		SCALE:				
DIMENSIONS ARE IN INCHES		MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.				
TOLERANCES ON FRACTIONS ± 1/64 DECIMALS ± .005 ANGLES ± 1/2°		REMOVE ALL BURRS AND SHARP EDGES				

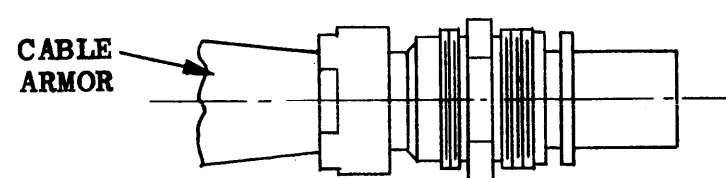
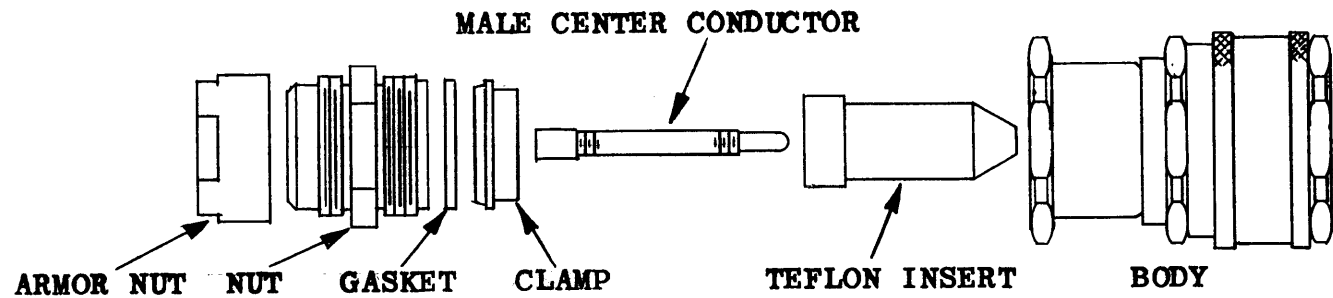
REQ. PER UNIT	MODEL	SECTION	ASS'Y. NO.	DATE
	TRC-5K			9-26-62
				10-27-61
USED ON				

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
STOCK SIZE			
INSTALLATION FOR AX-273-4 & AX-287-3 TO TRC-5K or TRC-3500-52U/52B			
MATERIAL			
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKER
		<i>[Signature]</i>	<i>[Signature]</i>
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.
		<i>[Signature]</i>	<i>[Signature]</i>
ID-264			

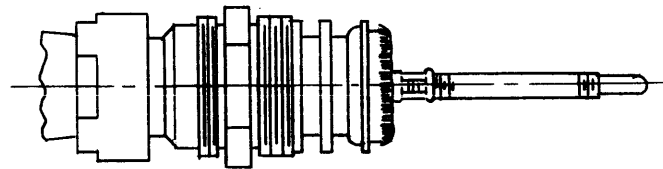
REVISIONS

SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD	APPD
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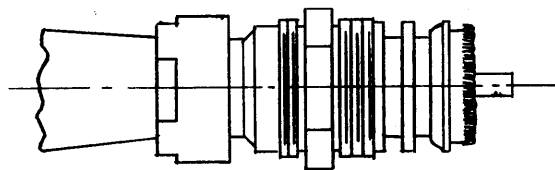
ID-291



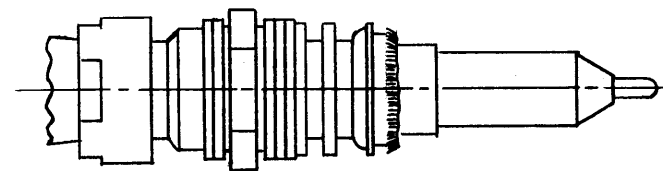
1. Cut end of cable even. Slide armor nut over cable armor. Bulge armor braid by pushing armor nut back on cable 6". Push nut and gasket over cable jacket. Make sure V groove on gasket is toward clamp.



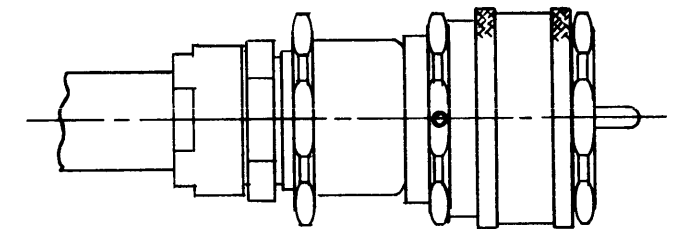
2. Remove cable jacket 9/16". (Make sure edge of jacket is evenly cut.) Push clamp over braid and seat clamp on edge of cable jacket. Cut exposed braid so that approx. 1/4" remains to form over shoulder of clamp. Comb out braid and fan back over shoulder of clamp. Cut off excess braid just short of exterior flange of clamp. Cut off cable dielectric, smooth and even, to the point where braid bends over clamp. (A cable dielectric facing tool is recommended for this purpose.) Cut exposed cable center conductor to 11/32" maximum.



3. Slip center conductor pin over exposed cable center conductor flush against cable dielectric face and crimp the pin. For crimping use either Thomas & Betts #21 disc on 12 ton power head T2B#13642, or #21 disc on T & B hand tool WT-117 or UT5-E. Crimp can also be performed with T & B's TBM-2 hand tool, (use red disc) by making two crimps 1/8" apart, the first crimp being as close to cable dielectric face as possible.



4. Screw teflon insert over center conductor pin and jam it tight against the face of the cable dielectric.



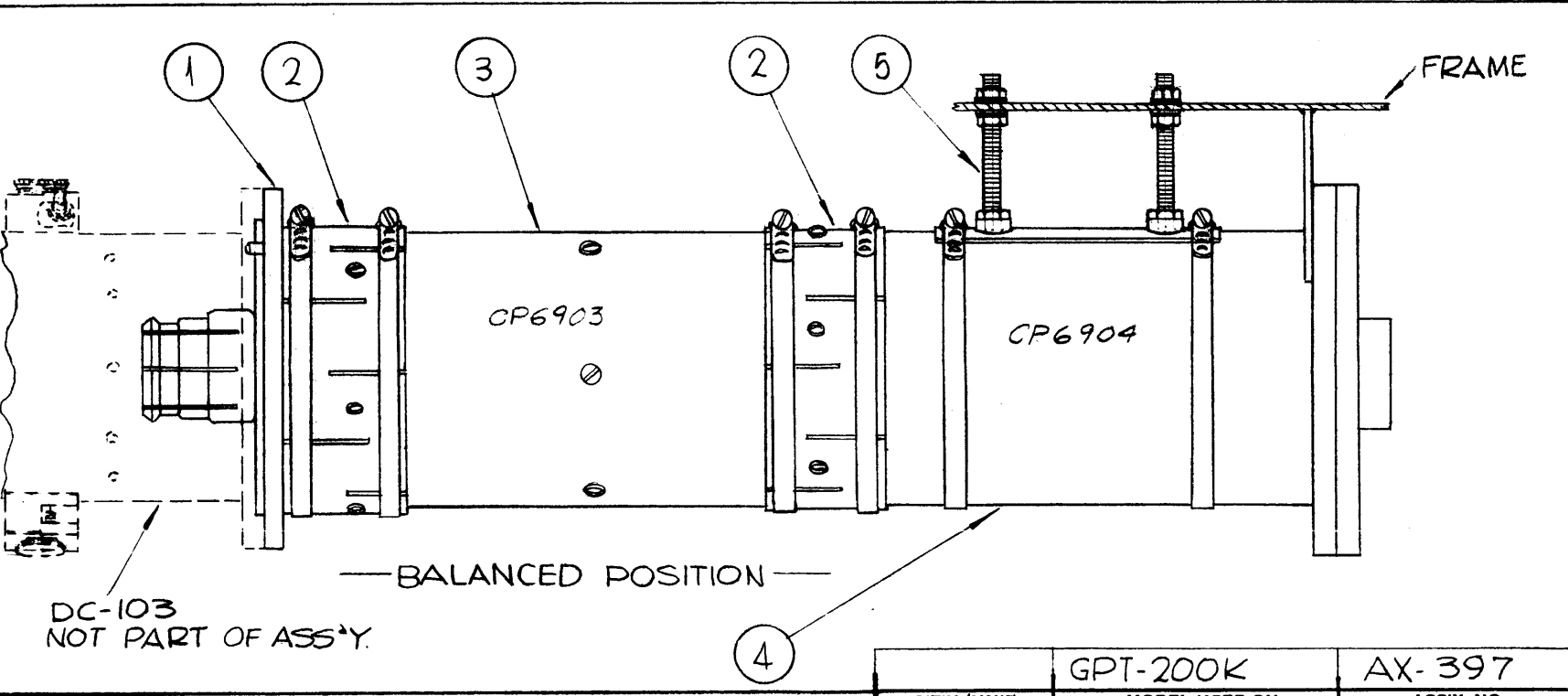
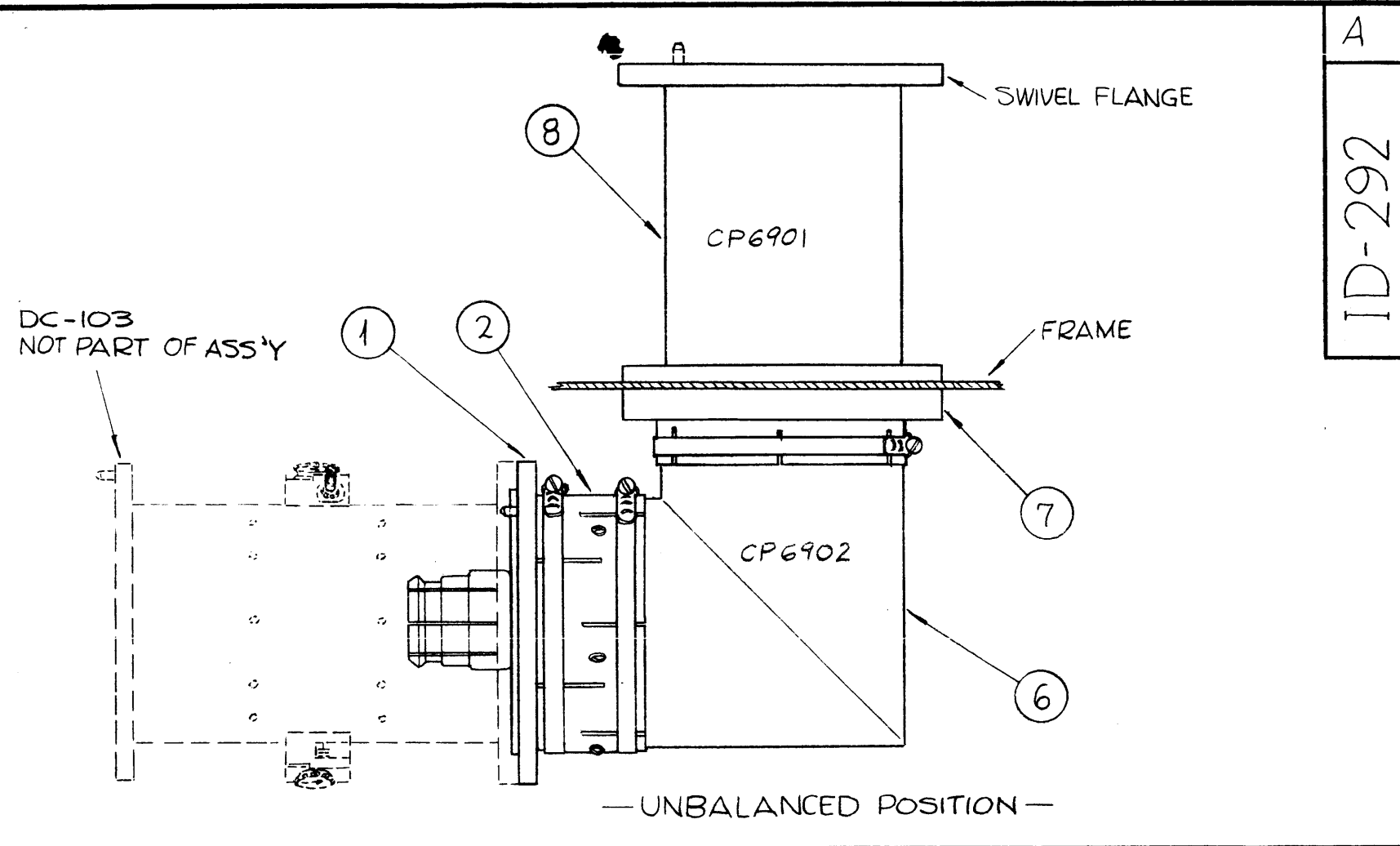
5. Slip plug body assembly over teflon insert as far back as possible. Holding body stationary screw and tighten nut securely with wrench. Straighten bulge in armor. Cut armor so that it can be clamped between nut and armor nut. Tighten armor nut securely on nut with wrench.

Note: When using non-armored cable, disregard all instructions pertaining to armor.

NOTES

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REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
<b>MARTINENGO LIST OF MATERIAL</b>				
MATERIAL			<b>THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK</b>	
FINISH			TITLE <b>ASSEMBLY INSTRUCTIONS FOR QDL PLUG</b>	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES			DRAWN <b>M TANTILLO</b> DATE <b>10-5-63</b>	FINAL APPROVAL <i>BP</i> DATE
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005			TOLERANCES ± 1/64 ANGLES ± 0° 30'	DATE <b>10-11-63</b>
SCALE			ELECT. DES. <i>[Signature]</i> DATE <b>10-7-63</b>	REV. LTR.
Q'TY./UNIT			<b>ID-291</b>	
MODEL USED ON			SHEET	
ASS'Y. NO.			REV. LTR.	



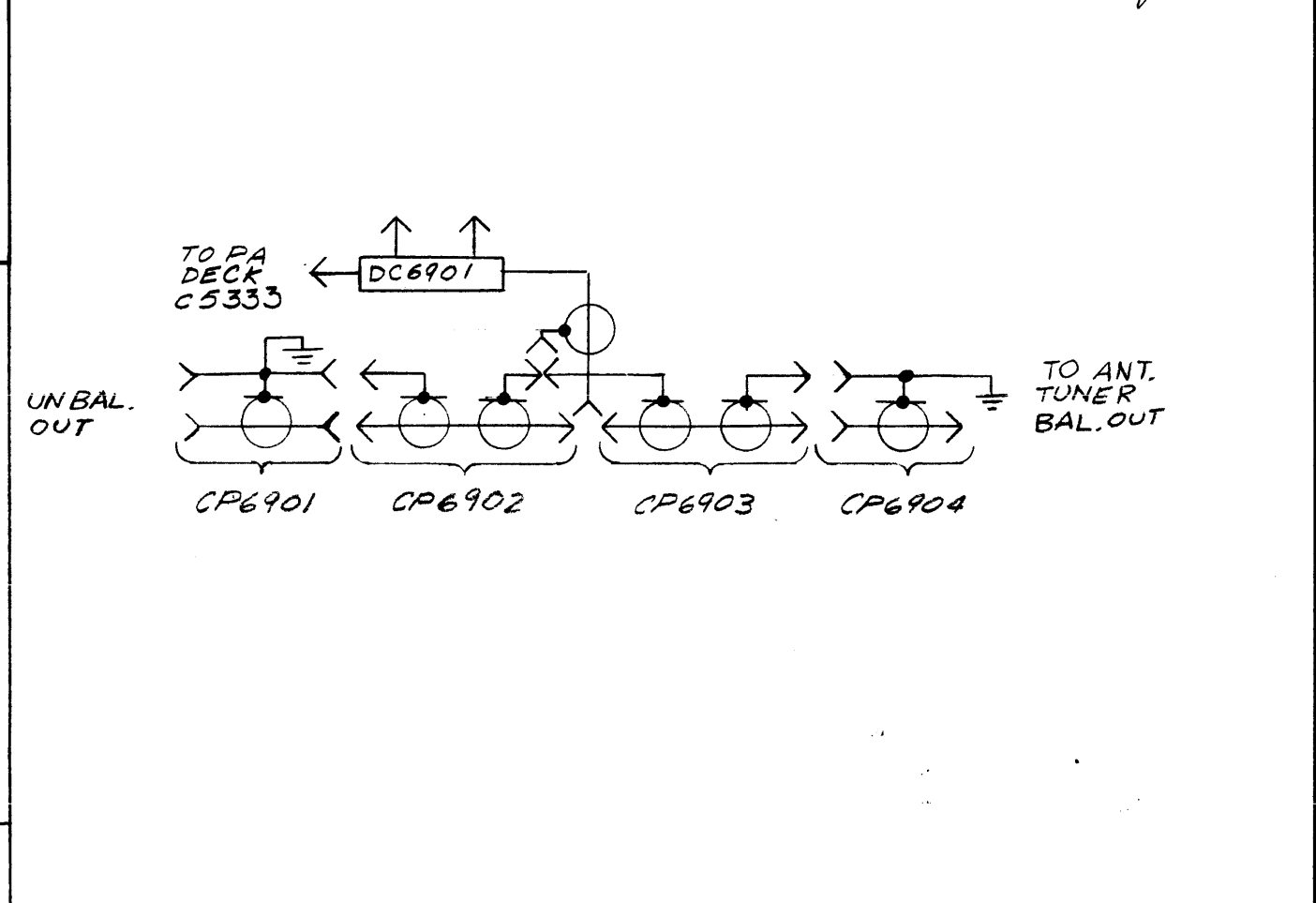
HARDWARE LEFT OUT FOR PURPOSE OF CLARITY.

**NOTES**

Q'TY./UNIT	GPT-200K	AX-397
SCALE	MODEL USED ON	ASS'Y. NO.
1/4 = 1"	CODE	A
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A  
ID-292

REVISIONS					
SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD APPD
0	ORIGINAL RELEASE FOR PRODUCTION	5-27-64	0	A.M.	
A	SCHEM. DETAIL & SYM. CP6901, 2, 3, & 4 ADDED	12/3/65	15287	A.V.V.	<i>[Signature]</i>



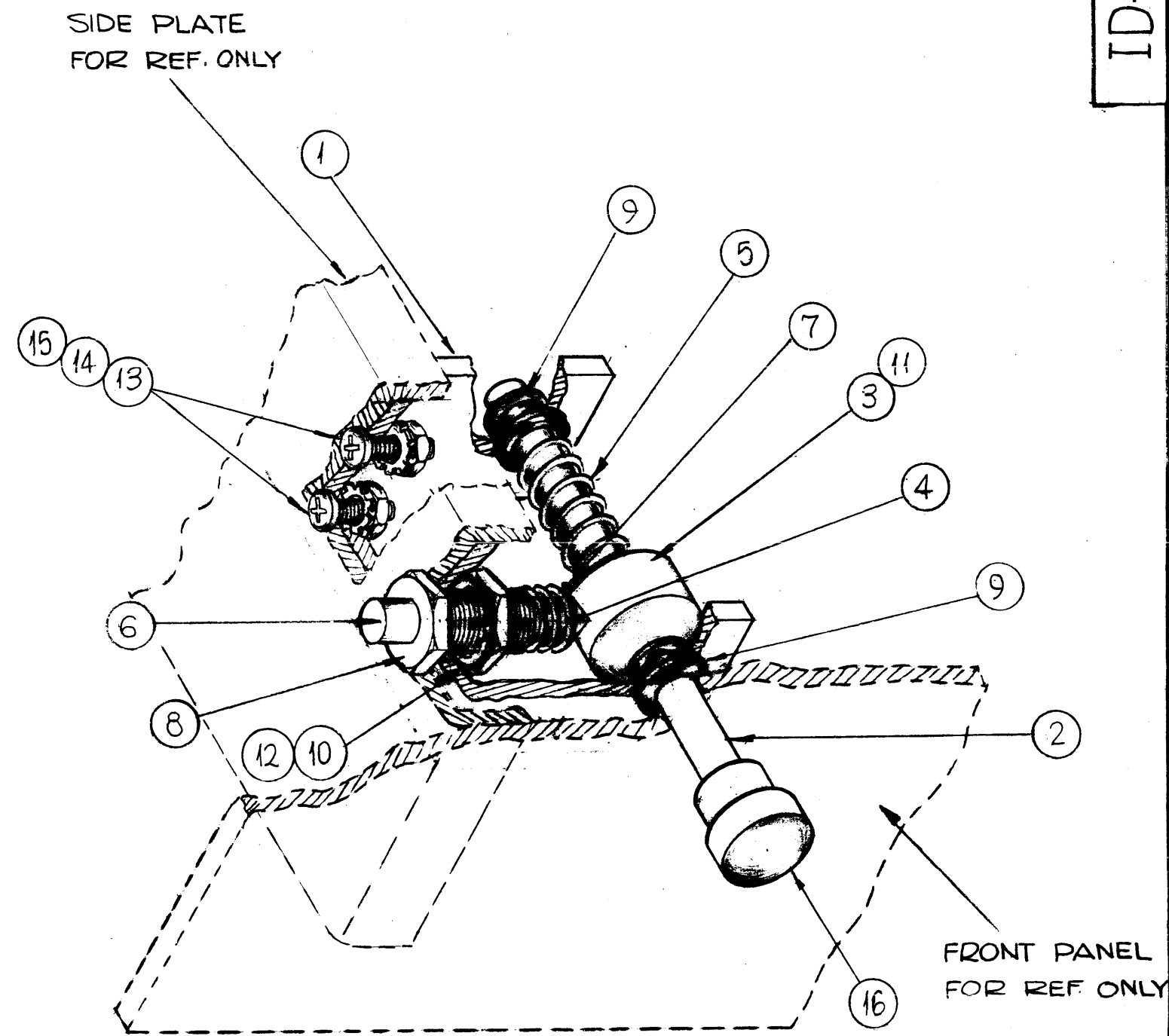
REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
1	8	PO-282	ADAPTOR, BULKHEAD LINE RF. TRANS.	
1	7	PO-301	ADAPTOR, LINE RF. TRANSMISSION	
1	6	PO-284	ELBOW, LINE RF TRANSMISSION UNFLANGED	
1	5	PO-293	HANGER, LINE	
1	4	PO-283	ADAPTOR, LINE RF. TRANSMISSION (RIGHT)	
1	3	PO-285	ADAPTOR, LINE RF. TRANSMISSION	
2	2	PO-298	COUPLING, LINE RF TRANSMISSION	
1	1	PO-281	ADAPTOR, LINE RF TRANSMISSION (LEFT)	

F. BUDETTI		LIST OF MATERIAL	
MATERIAL		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
FINISH		TITLE INSTALLATION, BALANCED & UNBALANCED (6 1/8)	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		DRAWN <i>SRG</i>	DATE 1-15-64
DECIMALS .X ± .05 .XX ± .01 .XXX ± .05		CHECKED <i>aa</i>	DATE
FRACTIONS ± 1/64 ANGLES ± 0° 30'		ELECT. DES. <i>SRG</i>	DATE 12/16/64
TOLERANCES		MECH. DES. <i>MC</i>	DATE 12/16/64
		FINAL APPROVAL <i>[Signature]</i>	
		ID-292	
		SHEET	
		REV. LTR. A	

ID-294 0

**REVISIONS**

SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD	APFD
X1	4 ITEMS DELETED					
X2	DRAWING WAS A-3350 & ITEMS 13,14,15,16 RE-INSTATED					
0	ORIGINAL RELEASE FOR PRODUCTION	5/28/64	0	A.M.		



QTY	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
1	16	HB-112-2	PUSH BUTTON	
2	15	NTH0832BN10	NUT, HEX	
2	14	LWE08MRN	WASHER, LOCK, EXTERNAL	
2	13	SCBP0832BN7	SCREW, MACHINE	
1	12	LWI37MRN	WASHER, LOCK, INTERNAL	
2	11	SLHCO632SP5	SETSCREW	
1	10	NTH3732BN16	NUT, HEX.	
2	9	BB-117-6	BEARING, SLEEVE, 2 FLANGE NYLON	
1	8	PM-526	BUSHING, MACHINE THD.	
1	7	PN-59-062-5	PIN, SPRING	
1	6	PM-527	PLUNGER	
1	5	SP-135	SPRING, COMPRESSION	
1	4	SP-118-2N	SPRING, COMPRESSION	
1	3	PM-528	CAM, PLUNGER	
1	2	PM-529	SHAFT, CAM	
1	1	MS-1491	BRACKET, LOCK	

REQ'D. ITEM PART NUMBER DESCRIPTION SYMBOL  
 F. BUDETTI LIST OF MATERIAL

MATERIAL THE TECHNICAL MATERIEL CORP.  
 FINISH MAMARONECK, NEW YORK

TITLE PANEL LOCK INSTALLATION

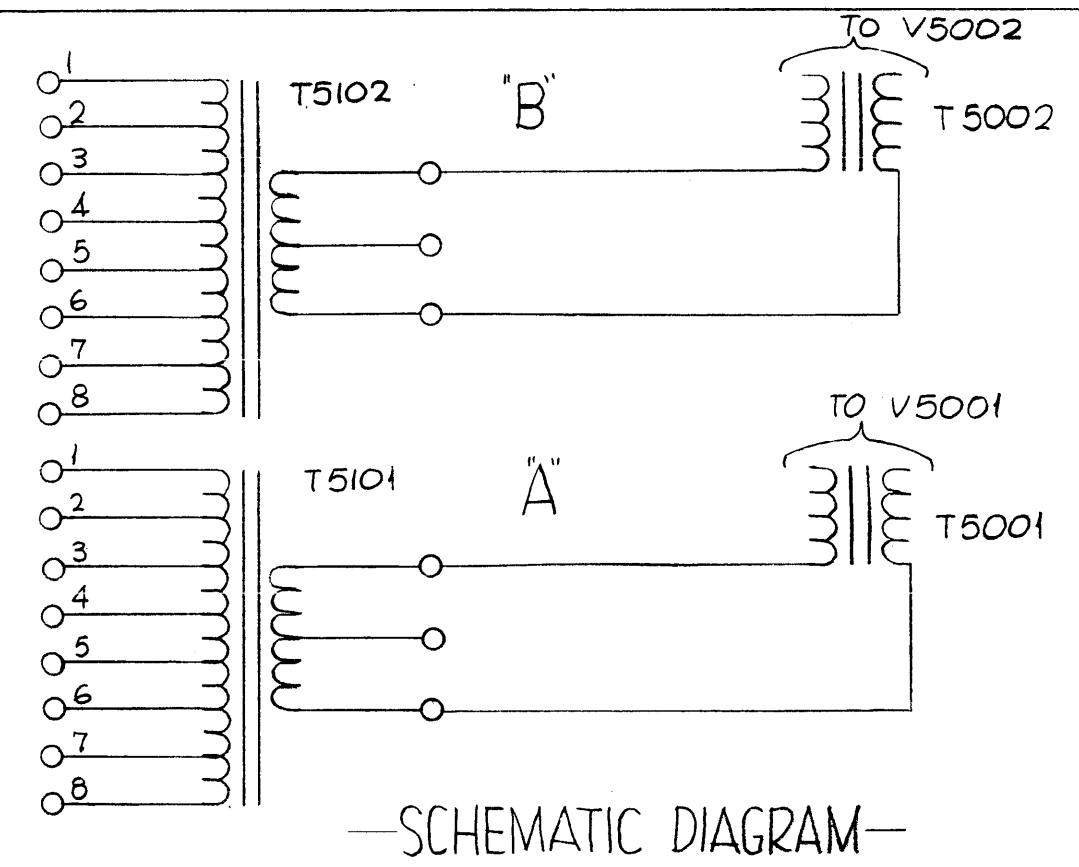
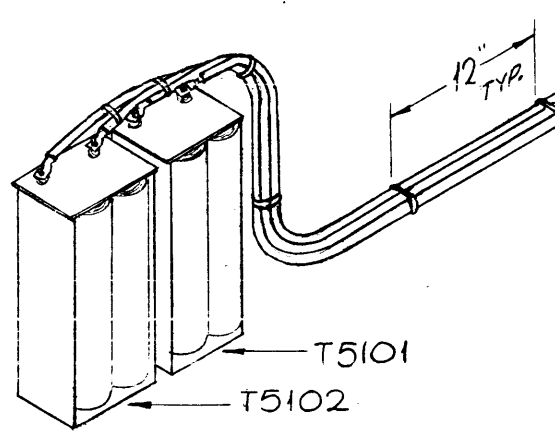
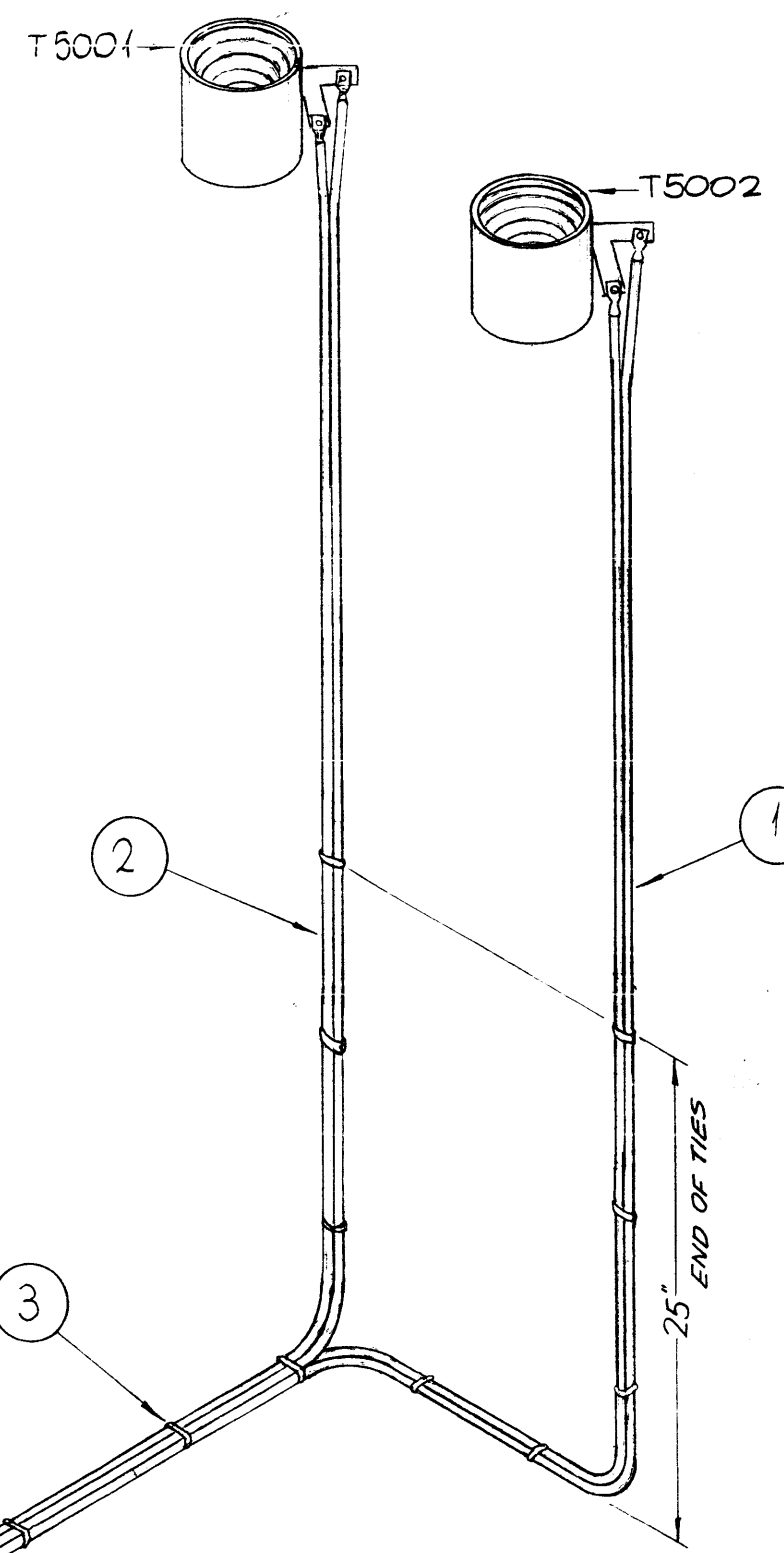
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		DRAWN J.F. VITRO	DATE 11-12-62	FINAL APPROVAL Rde	DATE
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005		CHECKED aa	DATE	ID-294	0
FRACTIONS ± 1/64 ANGLES ± 0° 30'		ELECT. DES. JB	DATE 7-11-64		
TOLERANCES		MECH. DES. ML	DATE 5/28/64	SHEET	

**NOTES**

GPT-200K  
 QTY./UNIT MODEL USED ON ASS'Y. NO.  
 SCALE # CODE A  
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ID-295

REVISIONS						
SYM	DESCRIPTION	DATE	F.M.N. NO	DRAFT	CHKD	APPD
0	ORIGINAL RELEASE FOR PRODUCTION	5-13-64	0	A.M.		



REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
	3	CU-142-5-0	STRAP, CABLE, ADJUSTABLE, PLASTIC	BLACK
	2	CA-793-31-11-6	LEAD, ELECTRICAL	
	2	CA-793-32-13-6	LEAD, ELECTRICAL	

F. BUDETTI		LIST OF MATERIAL			
MATERIAL		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
FINISH		TITLE CABLE, INSTALLATION			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		DRAWN SRG	DATE 2-6-64	FINAL APPROVAL RDC	
DECIMALS X ± .05 .XX ± .01 .XXX ± .005		CHECKED aa	DATE	DATE 5/13/64	
TOLERANCES		ELECT. DES. CB		ID-295	
FRACTIONS ± 1/64 ANGLES ± 0° 30'		MECH. DES. RC		SHEET	
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Q'TY./UNIT	MODEL USED ON	ASS'Y. NO.
1	GPT-200K	AX-393
SCALE	CODE	
#	A	